



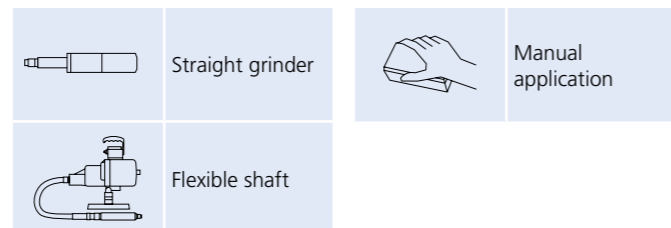


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For detailed information and ordering data for Poliflex® fine grinding points, please refer to Catalogue 204.

For detailed information and ordering data for diamond grinding points, please refer to Catalogue 205.

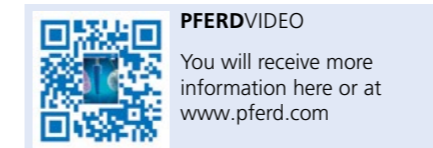


PFERD quality

PFERD mounted points are developed, manufactured and tested according to the highest quality standards.

Research and development, our own machine and plant construction, as well as the continuous monitoring of the production processes guarantee the high quality of PFERD products.

PFERD quality management is certified according to ISO 9001.



Cutting speeds

The diagram on the right allows you to determine the rotational speed from a given cutting speed. Recommended cutting speeds are stated in the introductory descriptions of the various hardness grades on the following pages. The recommended rotational speed can be taken from the product tables.

In the diagram, cutting speeds are represented by blue diagonal lines. Each vertical line represents a tool diameter and intersects the diagonal lines. From its point of intersection with the diagonal line for a given peripheral speed, proceed horizontally to the left margin where you will find the corresponding rotational speed of the mounted point and tool drive.

Example:
Mounted point outer dia. 20 mm
Hardness: M
Cutting speed: 30–50 m/s
Rotational speed: 28,600–47,700 RPM

Customer consultation

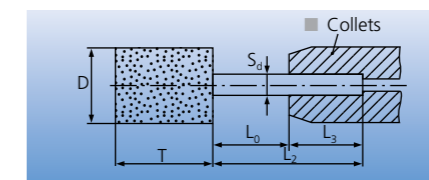
If you have any questions regarding the optimization of your grinding work or solutions to specific application problems, our sales representatives and technical advisors will be happy to help. Contact us! Our worldwide sales addresses can be found at: www.pferd.com

Products made to order

If you cannot find the solution for your particular application in our comprehensive product catalogue, we can produce mounted points in premium PFERD quality on request, tailor-made to meet the requirements of your job. We take account of your requirements and wishes, drawings, information on bonds and hardness, grit sizes, grit types, shapes, dimensions, shanks and packaging. Please contact our sales representatives! We will be happy to advise you.

Explanation of the code system according to EN 12413

- D = Mounted point outer dia.
- T = Mounted point width
- S_d = Shank dia.
- L₀ = Unsupported shank length
- L₂ = Shank length
- L₃ = Clamping length of shank



Safety notes

All mounted points supplied by PFERD are approved for a maximum operating speed of 50 m/s. Maximum permitted rotational speeds for the various shank lengths and shank diameters are defined in DIN 69170 based on EN 12413. These must be strictly adhered to in order to avoid buckling of the shank during use. Regardless of the shank length, the clamping length (L₃) in the machine collet must be at least 10 mm.

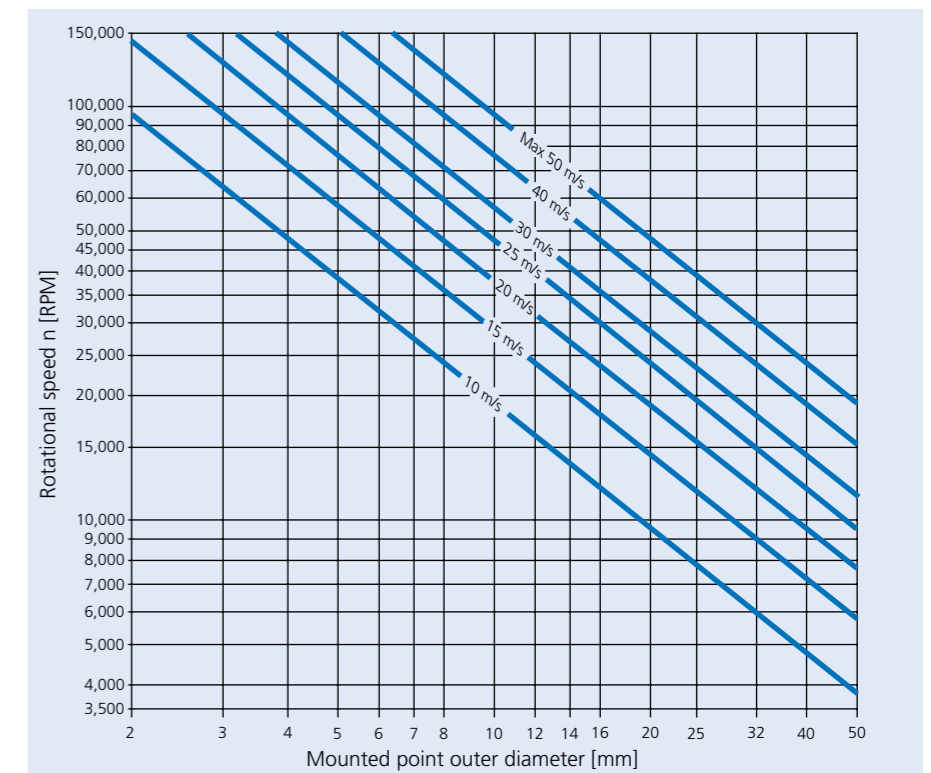
The maximum permitted rotational speed calculated in accordance with EN 12413 is determined by the following factors:

- Shape and dimensions of the mounted point
- Diameter of the steel shank S_d
- Unsupported shank length L₀

Each packaging of PFERD mounted points comes with rotational speed recommendations for a given unsupported shank length (L₀) of that product. In addition, the concentric accuracy and correct clamping of the tool drive must be ensured.

Tables with the maximum permitted rotational speed for the entire PFERD mounted point product range are available on request.

- = Wear eye protection!
- = Wear hearing protection!
- = Read the safety instructions!





PFERD offers a very extensive range of ceramic-bonded and resinoid-bonded mounted points. Designed to meet individual grinding tool application needs, these products come in a broad range of grain types, grit sizes, hardness grades and shapes. The mounted points are manufactured on modern production lines to high standards of dimensional accuracy and stability, consistent quality and close tolerances. To select the correct mounted point, the material, main fields

of application and specific operating requirements have to be taken into consideration.

This overview shows which types (abrasives, bonds and hardness grades) are suitable for the various materials and the tasks at hand.

How to find the best mounted point?

1 Material

The various material groups are colour-coded and form the starting point for the selection of the most appropriate mounted point.

2 Application

After the material, the application must be selected:

- General use
- Surface grinding
- Edge grinding

This differentiation is necessary in order to find the optimum mounted point and correct bond type. The mounted point bond, hardness and grain mix have a decisive impact on the abrasive performance, tool life and aggressiveness of the tools:

- For **general use**, the emphasis is on the balance between abrasive performance and tool life
- In **surface grinding**, the mounted points are subject to lower loads. This is why the

mounted point bond is comparatively soft and designed to give high stock removal

- In **edge grinding**, the mounted points must be dimensionally stable. This is why the mounted point bond is comparatively hard and designed for a long tool life

3 Mounted point hardness

After determining the application (see column 2) the hardness is selected in the horizontal row. The hardness grades of the bonds are arranged from soft to hard. The "highly

suitable" hardness is indicated by a black dot (●). Further "suitable" hardness grades are indicated by an open dot (○). Applications that have been optimized specifically for foundries are indicated by a blue asterisk (*).

4 Refer to the catalogue page

For more information about the hardness grades, mounted point shapes, dimensions and grit sizes, the corresponding catalogue pages are stated in the table.

1 Material group			Bond ▶
			3 Mounted point hardness ▶
			Abrasives ▶
			Recommended cutting speed ▶
			2 Application ▼
Steel, cast steel	Non-hardened, non-heat-treated steels up to 1200 N/mm ² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels	General use on edge and surface Surface grinding with high stock removal rate Edge grinding with high form stability
	Hardened, heat-treated steels over 1200 N/mm ² (> 38 HRC)	Tool steels, tempering steels, alloyed steels	General use on edge and surface Surface grinding with high stock removal rate Edge grinding with high form stability
	Cast steel	Non-alloyed cast steel, low-alloyed cast steel	Surface grinding with high stock removal rate Edge grinding with high form stability
Stainless steel (INOX)	Rust- and acid-resistant steels	Austenitic and ferritic stainless steels	Surface grinding with high stock removal rate Edge grinding with high form stability
Non-ferrous metals	Soft non-ferrous metals, non-ferrous metals	Aluminium alloys, brass, copper, zinc	
	Hard non-ferrous metals	Bronze, titanium, titanium alloys, hard aluminium alloys	General use on edge and surface
	High-temperature-resistant materials	Nickel-based and cobalt-based alloys (engine and turbine construction)	
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite EN-GJL (GG), with nodular graphite/nodular cast iron EN-GJS (GGG), white annealed cast iron EN-GJMW (GTW), black cast iron EN-GJMB (GTS)	Surface grinding with high stock removal rate Edge grinding and grinding of burning-in with high form stability
Plastics, other materials		Fibre-reinforced plastics, thermoplastics, rubber, wood	General use on edge and surface
			4 Catalogue page ▶

Resinoid bond				Vitrified bond				
Hardness L	Hardness N	Hardness D	Hardness F-ALU	Hardness J	Hardness K	Hardness M	Hardness O	Hardness R
ADW	AN	AH	CN	AWCO	ARN	ADW	AR	CU
35-50 m/s	35-50 m/s	5-20 m/s	20-40 m/s	30-50 m/s	30-50 m/s	30-50 m/s	25-40 m/s	30-50 m/s
						●		
○						●	○	
	○					○	●	
				●		●		
				●			○	
○					○	●	○*	
	○					○	●*	
●	○					○		
○							○	
○			●					
○			○	●				
○	○				●		○*	○*
○	○				○		○*	●*
		●	○					
26	28	38	37	23	31	8	12	33

● = highly suitable

○ = suitable

* = additional types for foundries


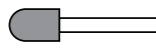
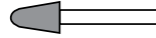
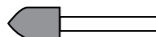
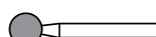
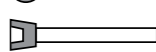




Explanation of the descriptions according to ISO 525

Cylindrical mounted point **ZY 2025 6 ADW 30 M 5 V**
 ① ② ③ ④ ⑤ ⑥ ⑦ ⑧

① Shapes according to DIN 69170

- ZY = Cylindrical 
- WR = Cylindrical with radius end 
- KE = Tapered 
- SP = Tree 
- KU = Ball 
- TO = Cup 

US shapes according to ANSI B74.2

Series W (cylindrical mounted points in inch dimensions)
 Series A and B (other shapes)

② Dimensions

The mounted point outer diameter D and mounted point width T in mm are the first digits of the description:

- 3 mm x 6 mm = 0306
- 20 mm x 25 mm = 2025**
- 50 mm x 13 mm = 5013

US dimensions

Series W cylindrical mounted points and series A and B mounted points are specified by a number (e.g. W 143).

③ Shanks

The shank diameter is given in the description. The shank length is determined as follows:
 Shank dia. 3 mm = 30 mm shank length
Shank dia. 6 mm = 40 mm shank length
 Shank dia. 8 mm = 40 mm shank length
 Shank dia. 1/8" = 1 1/4" shank length
 Shank dia. 1/4" = 1 1/2" shank length

④ Abrasives

In general, two grain types are used, with internationally defined designations according to ISO 525:

- A = Aluminium oxide (Al₂O₃)
- C = Silicon carbide (SiC)

In order to specify the exact grain mixture, classification beyond ISO 525 is necessary. The following abbreviations are used:

- AD = Aluminium oxide, dark red
- AW = Aluminium oxide, white
- AR = Aluminium oxide, pink
- AN = Aluminium oxide, regular
- AH = Bubble grain
- CN = Silicon carbide, green
- CU = Silicon carbide, grey
- CO = Ceramic oxide grain

ADW = Aluminium oxide mixture AD + AW

- ARN = Aluminium oxide mixture AR + AN
- ADR = Aluminium oxide mixture AD + AR
- AWCO = Aluminium oxide mixture AW + CO



⑤ Grit sizes according to ISO 525 and ISO 8486

The grit sizes of PFERD mounted points are correlated to the shape and diameter of the points.

In this example, the **grit size** is 30.

⑥ Hardness grades according to ISO 525

Abrasive hardness grades are classified using letters in alphabetical order to specify the hardness from soft to hard.

This example concerns a mounted point with **hardness M**.

⑦ Structure according to ISO 525

The internationally valid scale for structural density ranges from 1 = dense structure to 14 = open (porous) structure.

In this example, the structure number is specified by the figure 5.

⑧ Bond according to ISO 525

Bond types are designated by the following internationally standardized letter code:

- V = Vitrified bond**
- B = Resinoid bond



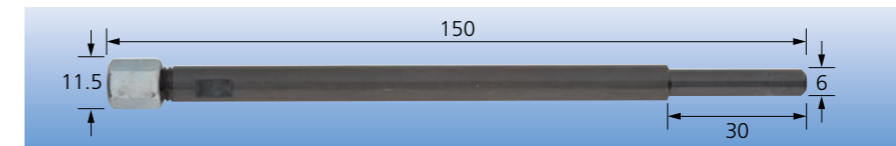
Mounted points with shank diameters of 3, 6 and 8 mm can be extended using drive spindle extensions. They enable hard-to-reach areas to be accessed. The spindle extension is mounted in the collet chuck of the tool drive (air-powered or electric), or in the handpiece of the flexible shaft. In some applications, spindle extensions are an efficient alternative to made-to-order mounted points with long shanks.

Safety notes:

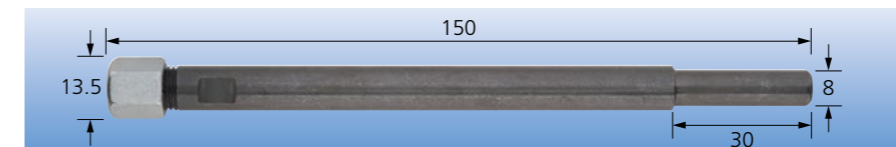
- When drive spindle extensions are used, for safety reasons the rotational speed must be greatly reduced to avoid buckling of the shank.
- For additional safety information, please refer to Catalogue 209.



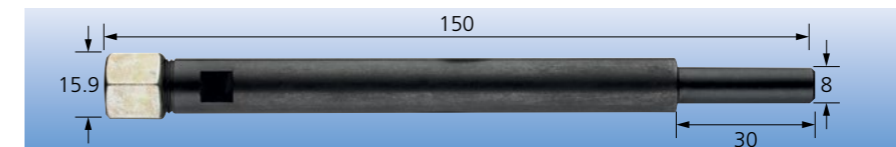
= Read the safety instructions!



Extension SPV 150-3 S6 for shank diameter 3 mm



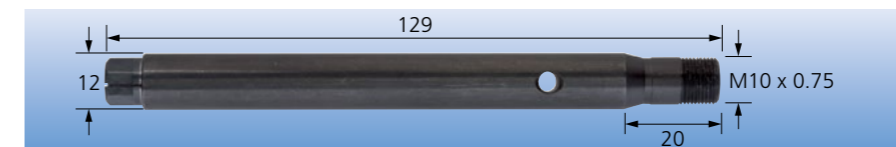
Extension SPV 150-6 S8 for shank diameter 6 mm



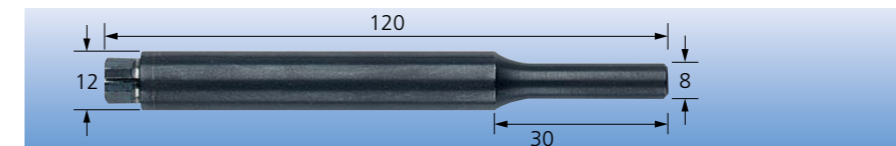
Extension SPV 150-8 S8 for shank diameter 8 mm



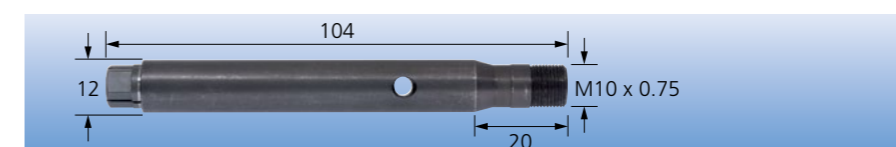
Extension SPV 100-6 S8 for shank diameter 6 mm



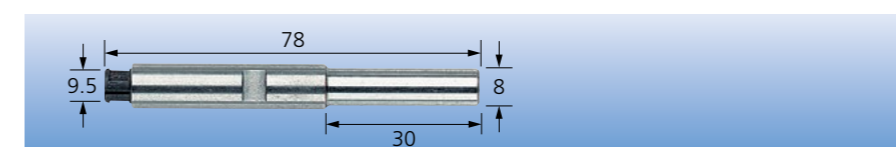
Extension SPV 100-6 SPG 6 for shank diameter 6 mm



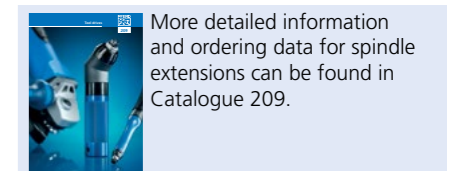
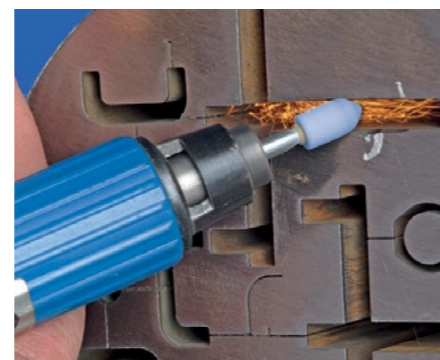
Extension SPV 75-6 S8 for shank diameter 6 mm

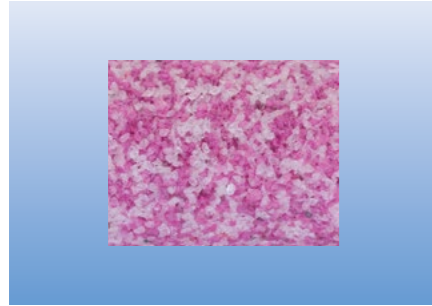


Extension SPV 75-6 SPG 6 for shank diameter 6 mm



Extension SPV 50-3 S8 for shank diameter 3 mm





Mounted points in **hardness M** are manufactured from a grain mix of tough, dark red and easy-to-break-down, white aluminium oxide in a vitrified bond. This grain combination leads to a good balance between stock removal rate and tool life. The hardness M is the most universally used bond for work on steel and cast steel.

Advantages:

- High abrasion and stock removal rate in multi-purpose use on steel materials
- Shortened grinding times and thus cost savings due to the high stock removal rate
- Especially suitable for work on surfaces and edges

Application examples:

- Grinding of high-speed steel (HSS) components
- Weld dressing on steel constructions

Recommendations for use:

- Mounted points of hardness M achieve their best performance at a cutting speed of 30 to 50 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

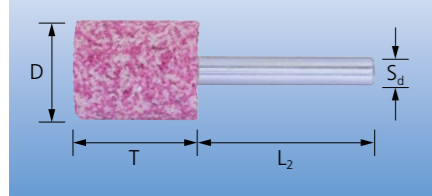
Ordering example:

EAN 4007220095706
ZY 1013 3 ADW 46 M 5 V
Please complete the description with the desired grit size.

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Hardness M, cylindrical ZY



Description	Grit size						Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60	80	100					
EAN 4007220											

Shank dia. 3 x 30 mm [S_d x L₂]

ZY 0205 3 ADW ... M 5 V	-	-	-	-	-	094365	W 141	2 x 5	200,000	201,800	10
ZY 0306 3 ADW ... M 5 V	-	-	-	-	-	094518	W 144	3 x 6	200,000	206,100	10
ZY 0408 3 ADW ... M 5 V	-	-	-	094679	-	094662	-	4 x 8	175,000	175,100	10
ZY 0510 3 ADW ... M 5 V	-	-	-	094877	-	094860	W 153	5 x 10	130,000	130,700	10
ZY 0613 3 ADW ... M 5 V	-	-	-	095140	-	095133	W 163	6 x 13	93,600	93,600	10
ZY 0810 3 ADW ... M 5 V	-	-	095331	-	095348	-	W 169	8 x 10	87,600	87,600	10
ZY 0816 3 ADW ... M 5 V	-	-	095522	-	659878	-	-	8 x 16	61,000	61,000	10
ZY 1002 3 ADW ... M 5 V	-	-	-	-	-	098653	W 172	10 x 2	85,000	95,400	10
ZY 1013 3 ADW ... M 5 V	-	-	095706	-	-	-	W 176	10 x 13	58,400	58,400	10
ZY 1303 3 ADW ... M 5 V	-	-	-	098783	-	098776	W 122	13 x 3	65,000	73,400	10

Shank dia. 6 x 40 mm [S_d x L₂]

ZY 0306 6 ADW ... M 5 V	-	-	-	-	-	094457	W 144	3 x 6	200,000	206,100	10
ZY 0408 6 ADW ... M 5 V	-	-	-	094570	-	-	-	4 x 8	175,000	177,400	10
ZY 0510 6 ADW ... M 5 V	-	-	-	094754	-	-	W 153	5 x 10	130,000	157,800	10
ZY 0613 6 ADW ... M 5 V	-	-	-	095034	-	095027	W 163	6 x 13	131,500	131,500	10
ZY 0810 6 ADW ... M 5 V	-	-	-	-	095263	-	W 169	8 x 10	110,000	119,300	10
ZY 0816 6 ADW ... M 5 V	-	-	095416	-	095423	-	-	8 x 16	110,000	119,300	10
ZY 1013 6 ADW ... M 5 V	-	-	095614	-	095621	-	W 176	10 x 13	85,000	95,400	10
ZY 1020 6 ADW ... M 5 V	-	-	095850	-	095867	-	W 177	10 x 20	85,000	95,400	10
ZY 1025 6 ADW ... M 5 V	-	-	095959	-	659892	-	W 178	10 x 25	83,200	83,200	10
ZY 1032 6 ADW ... M 5 V	-	-	096017	-	659908	-	W 179	10 x 32	62,800	62,800	10
ZY 1313 6 ADW ... M 5 V	-	-	096093	-	-	-	W 185	13 x 13	65,000	73,400	10

Continued on next page

Description	Grit size						Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60	80	100					
EAN 4007220											
ZY 1320 6 ADW ... M 5 V	-	-	096260	-	659915	-	W 186	13 x 20	65,000	73,400	10
ZY 1325 6 ADW ... M 5 V	-	-	096345	-	096352	-	W 187	13 x 25	65,000	66,000	10
ZY 1340 6 ADW ... M 5 V	-	-	098035	-	-	-	W 188	13 x 40	42,400	42,400	10
ZY 1604 6 ADW ... M 5 V	-	-	098912	-	660003	-	-	16 x 4	55,000	59,600	10
ZY 1620 6 ADW ... M 5 V	-	096451	-	096468	-	-	W 195	16 x 20	55,000	59,600	10
ZY 1632 6 ADW ... M 5 V	-	096598	-	096604	-	-	-	16 x 32	51,200	51,200	10
ZY 1640 6 ADW ... M 5 V	-	096727	-	-	-	-	-	16 x 40	40,500	40,500	10
ZY 1650 6 ADW ... M 5 V	-	659922	-	659939	-	-	W 197	16 x 50	31,300	31,300	10
ZY 2006 6 ADW ... M 5 V	-	-	099117	-	660010	-	W 201	20 x 6	43,000	47,700	10
ZY 2020 6 ADW ... M 5 V	-	096895	-	659946	-	-	W 204	20 x 20	43,000	47,700	10
ZY 2025 6 ADW ... M 5 V	-	096994	-	097007	-	-	W 205	20 x 25	43,000	47,700	10
ZY 2032 6 ADW ... M 5 V	-	097106	-	659953	-	-	W 206	20 x 32	41,100	41,100	10
ZY 2040 6 ADW ... M 5 V	-	097212	-	097229	-	-	W 207	20 x 40	32,400	32,400	10
ZY 2506 6 ADW ... M 5 V	-	-	099322	-	-	-	W 216	25 x 6	35,000	38,100	10
ZY 2525 6 ADW ... M 5 V	-	097335	-	659977	-	-	W 220	25 x 25	35,000	38,100	10
ZY 2532 6 ADW ... M 5 V	-	097434	-	-	-	-	-	25 x 32	32,900	32,900	10
ZY 3208 6 ADW ... M 5 V	-	099575	-	660034	-	-	W 226	32 x 8	27,000	29,800	5
ZY 3216 6 ADW ... M 5 V	099667	-	-	-	-	-	-	32 x 16	27,000	29,800	5
ZY 3220 6 ADW ... M 5 V	099773	-	660065	-	-	-	W 228	32 x 20	27,000	29,800	5
ZY 3232 6 ADW ... M 5 V	097595	-	097601	-	-	-	W 230	32 x 32	25,700	25,700	5
ZY 3240 6 ADW ... M 5 V	097717	-	659984	-	-	-	W 231	32 x 40	20,300	20,300	5
ZY 4006 6 ADW ... M 5 V	-	-	100455	-	-	-	W 235	40 x 6	22,000	23,800	5
ZY 4010 6 ADW ... M 5 V	-	099889	-	660072	-	-	W 236	40 x 10	22,000	23,800	5
ZY 4020 6 ADW ... M 5 V	100028	-	100035	-	-	-	-	40 x 20	22,000	23,800	5
ZY 4040 6 ADW ... M 5 V	097809	-	659991	-	-	-	W 238	40 x 40	16,200	16,200	5
ZY 5008 6 ADW ... M 5 V	-	100509	-	-	-	-	-	50 x 8	17,000	19,000	5
ZY 5013 6 ADW ... M 5 V	-	100189	-	660089	-	-	-	50 x 13	17,000	19,000	5
ZY 5025 6 ADW ... M 5 V	-	-	100325	-	-	-	W 242	50 x 25	17,000	19,000	5

Shank dia. 8 x 40 mm [S_d x L₂]

ZY 5025 8 ADW ... M 5 V	100554	-	-	-	-	-	W 242	50 x 25	17,000	19,000	5
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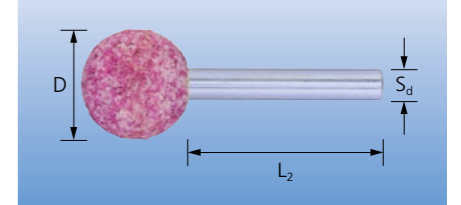
Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220101261
KU 16 6 ADW 30 M 5 V
Please complete the description with the desired grit size.

Hardness M, ball KU

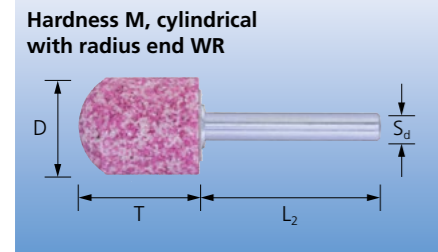


Description	Grit size				D [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60				
EAN 4007220								

Shank dia. 6 x 40 mm [S_d x L₂]

KU 13 6 ADW ... M 5 V	-	-	101209	-	13	65,000	73,400	10
KU 16 6 ADW ... M 5 V	-	101261	-	660140	16	55,000	59,600	10
KU 20 6 ADW ... M 5 V	-	101339	-	101346	20	43,000	47,700	10
KU 25 6 ADW ... M 5 V	-	-	-	660164	25	35,000	38,100	10
KU 32 6 ADW ... M 5 V	660171	-	660188	-	32	27,000	29,800	5





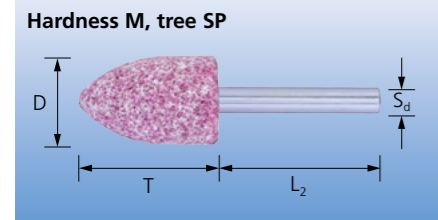
Description	Grit size				D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	30	46	60	80				
EAN 4007220								
Shank dia. 6 x 40 mm [S_d x L₂]								
WR 1320 6 ADW ... M 5 V	-	660096	-	660102	13 x 20	65,000	73,400	10
WR 2025 6 ADW ... M 5 V	660119	-	660126	-	20 x 25	43,000	47,700	10

Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**660119**
WR 2025 6 ADW **30** M 5 V
Please complete the description with the desired grit size.



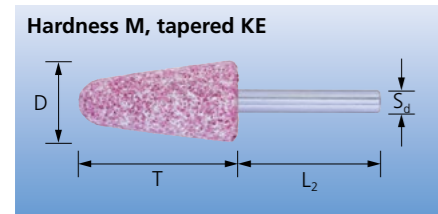
Description	Grit size				D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	30	46	60	80				
EAN 4007220								
Shank dia. 6 x 40 mm [S_d x L₂]								
SP 0816 6 ADW ... M 5 V	-	102008	-	-	8 x 16	110,000	119,300	10
SP 1320 6 ADW ... M 5 V	-	102138	-	660249	13 x 20	65,000	73,400	10
SP 2032 6 ADW ... M 5 V	102237	-	660256	-	20 x 32	43,000	47,700	10
SP 2050 6 ADW ... M 5 V	102312	-	-	-	20 x 50	30,500	30,500	10
SP 2540 6 ADW ... M 5 V	660270	-	-	-	25 x 40	35,000	35,000	10

Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**102138**
SP 1320 6 ADW **46** M 5 V
Please complete the description with the desired grit size.



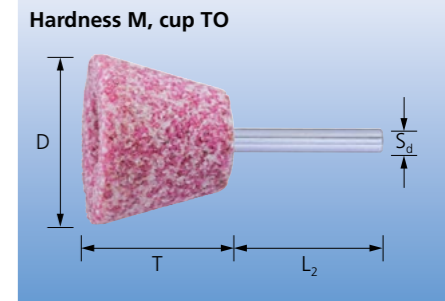
Description	Grit size					D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60	80				
EAN 4007220									
Shank dia. 6 x 40 mm [S_d x L₂]									
KE 1025 6 ADW ... M 5 V	-	-	102763	-	102770	10 x 25	85,000	95,400	10
KE 1645 6 ADW ... M 5 V	-	-	102862	-	660300	16 x 45	52,000	52,000	10
KE 2032 6 ADW ... M 5 V	-	102671	-	660294	-	20 x 32	43,000	47,700	10
KE 2040 6 ADW ... M 5 V	-	102961	-	660348	-	20 x 40	43,000	47,700	10
KE 2525 6 ADW ... M 5 V	-	102534	-	-	-	25 x 25	35,000	38,100	10
KE 2545 6 ADW ... M 5 V	-	534687	-	660317	-	25 x 45	34,000	34,000	10
KE 2570 6 ADW ... M 5 V	-	103043	-	-	-	25 x 70	20,400	20,400	10
KE 3232 6 ADW ... M 5 V	660287	-	102596	-	-	32 x 32	27,000	29,800	5
Shank dia. 8 x 40 mm [S_d x L₂]									
KE 3250 8 ADW ... M 5 V	660355	-	-	-	-	32 x 50	27,000	29,800	5

Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**102671**
KE 2032 6 ADW **30** M 5 V
Please complete the description with the desired grit size.



Description	Grit size		D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	60				
EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L₂]						
TO 2016 6 ADW ... M 5 V	-	660942	20 x 16	43,000	47,700	10
TO 4032 6 ADW ... M 5 V	660959	-	40 x 32	22,000	23,800	5

Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**660942**
TO 2016 6 ADW **60** M 5 V
Please complete the description with the desired grit size.

Explanation of the code system:

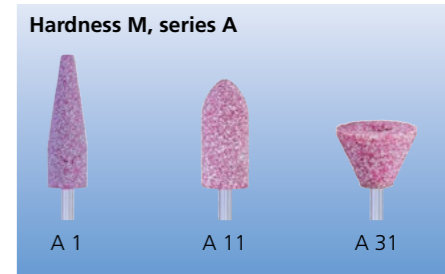
D = Mounted point outer dia.
T = Mounted point width

Ordering example:

EAN 4007220**114582**
A 1 6,3 ADW 30 M 5 V

Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

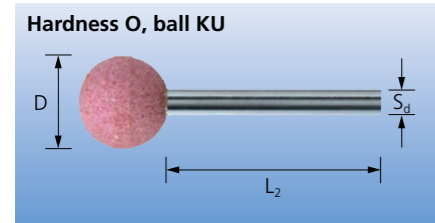


Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]						
A 31 6 ADW 30 M 5 V	30	117347	35 x 25	25,000	27,300	5
Shank dia. 6.35 x 40 mm [S_d x L₂]						
A 1 6,3 ADW 30 M 5 V	30	114582	19 x 64	33,500	33,500	10
A 11 6,3 ADW 30 M 5 V	30	114681	22 x 50	30,400	30,400	10





Description	Grit size						Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60	80	100					
	EAN 4007220										
ZY 4020 6 AR ... O 5 V	100042	-	100059	-	-	-	-	40 x 20	16,000	23,800	5
ZY 4040 6 AR ... O 5 V	097816	-	097823	-	-	-	W 238	40 x 40	16,000	16,200	5
ZY 5008 6 AR ... O 5 V	-	100516	-	-	-	-	-	50 x 8	13,000	19,000	5
ZY 5013 6 AR ... O 5 V	-	100202	-	-	-	-	-	50 x 13	13,000	19,000	5
ZY 5025 6 AR ... O 5 V	100332	-	100349	-	-	-	W 242	50 x 25	13,000	19,000	5
Shank dia. 6.35 x 40 mm [S_d x L₂]											
ZY 2525 6,3 AR ... O 5 V	-	117019	-	-	-	-	W 220	25 x 25	26,000	37,500	10
Shank dia. 8 x 40 mm [S_d x L₂]											
ZY 3240 8 AR ... O 5 V	098196	-	-	-	-	-	W 231	32 x 40	21,000	29,800	5
ZY 4040 8 AR ... O 5 V	098271	-	-	-	-	-	W 238	40 x 40	16,000	23,800	5



Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**101506**
KU 10 6 AR **80** O 5 V
Please complete the description with the desired grit size.

Description	Grit size						D [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60	80	100				
	EAN 4007220									
Shank dia. 3 x 30 mm [S_d x L₂]										
KU 03 3 AR ... O 5 V	-	-	-	-	-	101018	3	200,000	300,200	10
KU 05 3 AR ... O 5 V	-	-	-	101100	-	101094	5	130,000	190,900	10
KU 08 3 AR ... O 5 V	-	-	101551	-	101568	-	8	85,000	116,200	10
KU 10 3 AR ... O 5 V	-	-	101520	-	101537	-	10	65,000	83,300	10
KU 13 3 AR ... O 5 V	-	-	101605	-	101612	-	13	50,000	54,000	10
Shank dia. 6 x 40 mm [S_d x L₂]										
KU 03 6 AR ... O 5 V	-	-	-	-	-	100981	3	200,000	317,300	10
KU 05 6 AR ... O 5 V	-	-	-	101056	-	101049	5	130,000	190,900	10
KU 08 6 AR ... O 5 V	-	-	101148	-	101155	-	8	85,000	119,300	10
KU 10 6 AR ... O 5 V	-	-	101490	-	101506	-	10	65,000	95,400	10
KU 13 6 AR ... O 5 V	-	-	101216	-	101223	-	13	50,000	73,400	10
KU 16 6 AR ... O 5 V	-	101278	-	101285	-	-	16	42,000	59,600	10
KU 20 6 AR ... O 5 V	-	101353	-	101360	-	-	20	33,000	47,700	10
KU 25 6 AR ... O 5 V	-	101391	-	101407	-	-	25	26,000	38,100	10
KU 32 6 AR ... O 5 V	101445	-	101452	-	-	-	32	21,000	29,800	5

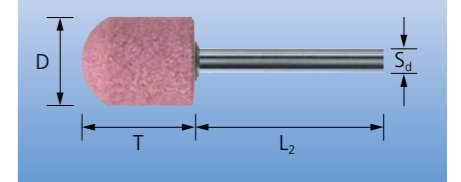
Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**100851**
WR 0816 6 AR **46** O 5 V
Please complete the description with the desired grit size.

Hardness O, cylindrical with radius end WR



Description	Grit size					D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	30	46	60	80	100				
	EAN 4007220								
Shank dia. 3 x 30 mm [S_d x L₂]									
WR 0306 3 AR ... O 5 V	-	-	-	-	100745	3 x 6	200,000	219,800	10
WR 0510 3 AR ... O 5 V	-	-	100837	-	100820	5 x 10	130,000	136,500	10
Shank dia. 6 x 40 mm [S_d x L₂]									
WR 0306 6 AR ... O 5 V	-	-	-	-	100714	3 x 6	200,000	219,800	10
WR 0510 6 AR ... O 5 V	-	-	100783	-	-	5 x 10	130,000	168,400	10
WR 0816 6 AR ... O 5 V	-	100851	-	100868	-	8 x 16	85,000	119,300	10
WR 1320 6 AR ... O 5 V	-	100905	-	100912	-	13 x 20	50,000	73,400	10
WR 2025 6 AR ... O 5 V	100943	-	100950	-	-	20 x 25	33,000	47,700	10

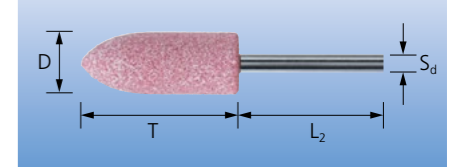
Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

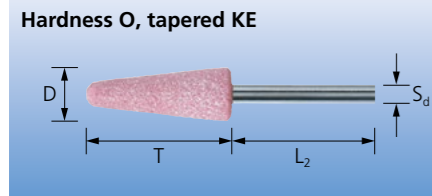
EAN 4007220**102152**
SP 1320 6 AR **46** O 5 V
Please complete the description with the desired grit size.

Hardness O, tree SP



Description	Grit size					D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	30	46	60	80	100				
	EAN 4007220								
Shank dia. 3 x 30 mm [S_d x L₂]									
SP 0306 3 AR ... O 5 V	-	-	-	-	101810	3 x 6	200,000	252,000	10
SP 0510 3 AR ... O 5 V	-	-	101940	-	101933	5 x 10	130,000	149,500	10
SP 0816 3 AR ... O 5 V	-	102084	-	102091	-	8 x 16	72,800	72,800	10
Shank dia. 6 x 40 mm [S_d x L₂]									
SP 0306 6 AR ... O 5 V	-	-	-	-	101773	3 x 6	200,000	255,500	10
SP 0510 6 AR ... O 5 V	-	-	101872	-	101865	5 x 10	130,000	190,900	10
SP 0816 6 AR ... O 5 V	-	102015	-	102022	-	8 x 16	85,000	119,300	10
SP 1320 6 AR ... O 5 V	-	102152	-	102169	-	13 x 20	50,000	73,400	10
SP 2032 6 AR ... O 5 V	102244	-	102251	-	-	20 x 32	33,000	47,700	10
SP 2050 6 AR ... O 5 V	102329	-	-	-	-	20 x 50	30,500	30,500	10
SP 2540 6 AR ... O 5 V	102350	-	-	-	-	25 x 40	26,000	35,000	10





Hardness O, tapered KE

Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220102688
KE 2032 6 AR 30 O 5 V
Please complete the description with the desired grit size.

Description	Grit size					D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60	80				
EAN 4007220									

Shank dia. 3 x 30 mm [S_d x L₂]

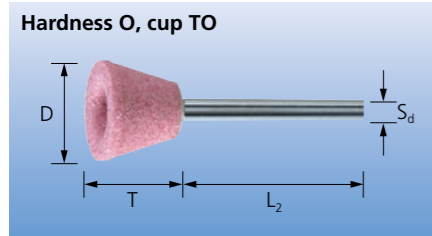
KE 1010 3 AR ... O 5 V	-	-	102404	-	-	10 x 10	65,000	95,400	10
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Shank dia. 6 x 40 mm [S_d x L₂]

KE 1010 6 AR ... O 5 V	-	-	102374	-	-	10 x 10	65,000	95,400	10
KE 1025 6 AR ... O 5 V	-	-	102787	-	102794	10 x 25	65,000	95,400	10
KE 1313 6 AR ... O 5 V	-	-	102428	-	-	13 x 13	50,000	73,400	10
KE 1616 6 AR ... O 5 V	-	102466	-	102473	-	16 x 16	42,000	59,600	10
KE 1645 6 AR ... O 5 V	-	-	102879	-	102886	16 x 45	42,000	52,000	10
KE 2020 6 AR ... O 5 V	-	102497	-	102503	-	20 x 20	33,000	47,700	10
KE 2032 6 AR ... O 5 V	-	102688	-	102695	-	20 x 32	33,000	47,700	10
KE 2040 6 AR ... O 5 V	-	102978	-	102985	-	20 x 40	33,000	47,700	10
KE 2525 6 AR ... O 5 V	-	102541	-	102558	-	25 x 25	26,000	38,100	10
KE 2545 6 AR ... O 5 V	-	102923	-	102930	-	25 x 45	26,000	34,000	10
KE 2570 6 AR ... O 5 V	-	103067	-	-	-	25 x 70	20,400	20,400	10
KE 3232 6 AR ... O 5 V	102602	-	102619	-	-	32 x 32	21,000	29,800	5

Shank dia. 8 x 40 mm [S_d x L₂]

KE 3250 8 AR ... O 5 V	103098	-	-	-	-	32 x 50	21,000	29,800	5
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Hardness O, cup TO

Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220103173
TO 3225 6 AR 24 O 5 V
Please complete the description with the desired grit size.

Description	Grit size				D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60				
EAN 4007220								

Shank dia. 6 x 40 mm [S_d x L₂]

TO 2016 6 AR ... O 5 V	-	103128	-	103135	20 x 16	33,000	47,700	10
TO 2520 6 AR ... O 5 V	-	103142	-	-	25 x 20	26,000	38,100	10
TO 3225 6 AR ... O 5 V	103173	-	103180	-	32 x 25	21,000	29,800	5



Hardness O, series A and B

Explanation of the code system:

D = Mounted point outer dia.
T = Mounted point width

Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220117101
A 1 6 AR 30 O 5 V



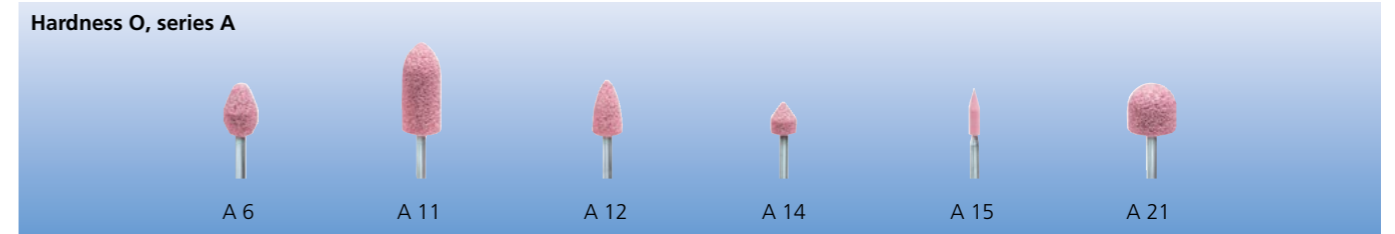
Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 6 x 40 mm [S_d x L₂]

A 1 6 AR 30 O 5 V	30	117101	19 x 64	30,400	30,400	10
A 2 6 AR 30 O 5 V	30	117125	25 x 32	26,000	37,500	10
A 3 6 AR 30 O 5 V	30	117149	25 x 70	18,600	18,600	10
A 4 6 AR 30 O 5 V	30	117163	32 x 32	21,000	30,000	5
A 5 6 AR 30 O 5 V	30	117170	19 x 29	35,000	49,900	10

Shank dia. 6.35 x 40 mm [S_d x L₂]

A 1 6,3 AR 30 O 5 V	30	114599	19 x 64	33,500	33,500	10
A 2 6,3 AR 30 O 5 V	30	114612	25 x 32	26,000	37,500	10
A 3 6,3 AR 30 O 5 V	30	114636	25 x 70	18,600	18,600	10
A 4 6,3 AR 30 O 5 V	30	114650	32 x 32	21,000	30,000	5
A 5 6,3 AR 30 O 5 V	30	114667	19 x 29	35,000	49,900	10



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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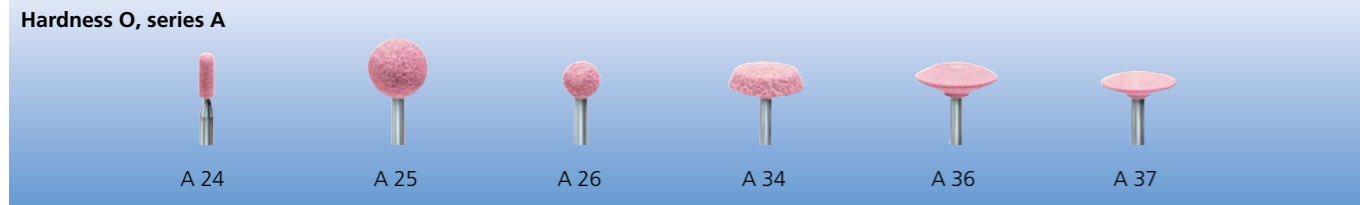
Shank dia. 6 x 40 mm [S_d x L₂]

A 6 6 AR 30 O 5 V	30	117187	19 x 29	35,000	49,900	10
A 11 6 AR 30 O 5 V	30	117200	22 x 50	27,600	27,600	10
A 12 6 AR 30 O 5 V	30	117224	17 x 32	40,000	54,500	10
A 14 6 AR 30 O 5 V	30	117248	17 x 22	40,000	54,500	10
A 15 6 AR 60 O 5 V	60	117262	6 x 27	100,000	112,900	10
A 15 6 AR 100 O 5 V	100	117255	6 x 27	100,000	112,900	10
A 21 6 AR 30 O 5 V	30	117279	25 x 25	26,000	37,500	10

Shank dia. 6.35 x 40 mm [S_d x L₂]

A 11 6,3 AR 30 O 5 V	30	114698	22 x 50	30,400	30,400	10
A 12 6,3 AR 30 O 5 V	30	114711	17 x 32	40,000	54,500	10
A 15 6,3 AR 60 O 5 V	60	114759	6 x 27	100,000	112,900	10
A 21 6,3 AR 30 O 5 V	30	114766	25 x 25	26,000	37,500	10





Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 6 x 40 mm [S_d x L₂]

A 24 6 AR 60 O 5 V	60	117316	6 x 19	100,000	117,400	10
A 24 6 AR 100 O 5 V	100	117309	6 x 19	100,000	117,400	10
A 25 6 AR 30 O 5 V	30	117323	25	26,000	37,500	10
A 26 6 AR 30 O 5 V	30	117330	16	42,000	60,000	10
A 34 6 AR 30 O 5 V	30	117385	38 x 10	18,000	25,000	5
A 36 6 AR 60 O 5 V	60	117415	41 x 10	16,000	23,100	5
A 37 6 AR 60 O 5 V	60	117422	32 x 6	21,000	30,000	5

Shank dia. 6.35 x 40 mm [S_d x L₂]

A 24 6,3 AR 60 O 5 V	60	114803	6 x 19	100,000	117,400	10
A 25 6,3 AR 30 O 5 V	30	114810	25	26,000	37,500	10
A 36 6,3 AR 60 O 5 V	60	114902	41 x 10	16,000	23,100	5
A 37 6,3 AR 60 O 5 V	60	114919	32 x 6	21,000	30,000	5



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 3 x 30 mm [S_d x L₂]

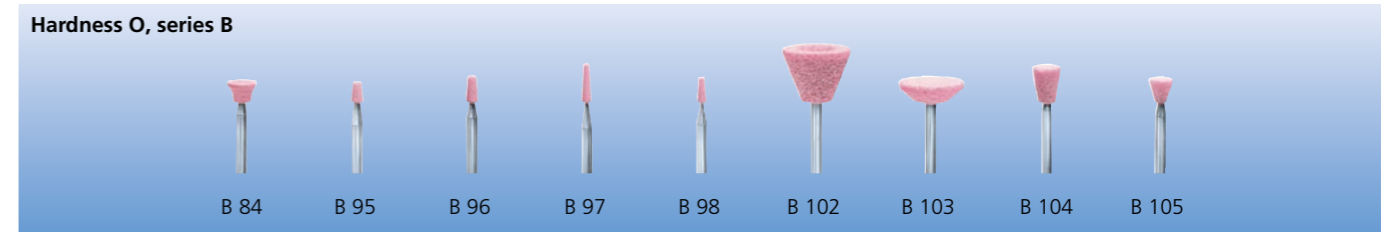
B 43 3 AR 100 O 5 V	100	117453	6 x 8	100,000	149,200	10
B 44 3 AR 100 O 5 V	100	117460	6 x 10	100,000	141,100	10
B 45 3 AR 100 O 5 V	100	117477	5 x 8	130,000	181,900	10
B 46 3 AR 100 O 5 V	100	117484	3 x 8	200,000	267,100	10
B 51 3 AR 80 O 5 V	80	117507	11 x 19	60,000	63,600	10
B 52 3 AR 46 O 5 V	46	117514	10 x 19	65,000	66,200	10
B 52 3 AR 80 O 5 V	80	117521	10 x 19	65,000	66,200	10
B 53 3 AR 60 O 5 V	60	117545	6 x 16	100,000	149,200	10
B 53 3 AR 100 O 5 V	100	117538	6 x 16	100,000	149,200	10
B 54 3 AR 60 O 5 V	60	117569	6 x 13	100,000	101,500	10
B 54 3 AR 100 O 5 V	100	117552	6 x 13	100,000	101,500	10
B 55 3 AR 100 O 5 V	100	117576	3 x 6	200,000	257,000	10
B 61 3 AR 80 O 5 V	80	117590	19 x 8	35,000	45,000	10



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 3 x 30 mm [S_d x L₂]

B 64 3 AR 100 O 5 V	100	117637	6 x 2	100,000	149,200	10
B 69 3 AR 100 O 5 V	100	117668	8 x 2	85,000	120,800	10
B 70 3 AR 100 O 5 V	100	117675	19 x 3	35,000	49,900	10
B 71 3 AR 100 O 5 V	100	117682	16 x 2	42,000	60,000	10
B 72 3 AR 100 O 5 V	100	117699	13 x 3	50,000	75,100	10
B 73 3 AR 100 O 5 V	100	117705	13 x 3	50,000	75,100	10
B 81 3 AR 100 O 5 V	100	117712	19 x 8	35,000	49,900	10
B 82 3 AR 100 O 5 V	100	117736	13 x 6	50,000	75,100	10



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 3 x 30 mm [S_d x L₂]

B 84 3 AR 100 O 5 V	100	117750	8 x 5	85,000	120,800	10
B 95 3 AR 100 O 5 V	100	117798	3 x 5	200,000	260,300	10
B 96 3 AR 100 O 5 V	100	117804	3 x 6	200,000	236,100	10
B 97 3 AR 100 O 5 V	100	117811	2 x 10	107,300	107,300	10
B 98 3 AR 100 O 5 V	100	117828	2 x 6	168,300	168,300	10
B 102 3 AR 80 O 5 V	80	117842	16 x 13	42,000	46,400	10
B 103 3 AR 80 O 5 V	80	117866	16 x 5	42,000	60,000	10
B 104 3 AR 80 O 5 V	80	117873	8 x 10	85,000	104,500	10
B 105 3 AR 100 O 5 V	100	117880	6 x 6	100,000	149,200	10



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 3 x 30 mm [S_d x L₂]

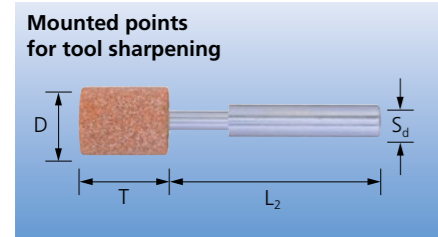
B 111 3 AR 80 O 5 V	80	117910	11 x 17	47,700	47,700	10
B 114 3 AR 100 O 5 V	100	117958	6 x 10	100,000	136,900	10
B 115 3 AR 100 O 5 V	100	117965	2 x 3	200,000	299,400	10
B 121 3 AR 46 O 5 V	46	117972	13	50,000	56,200	10

Continued on next page





Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
B 122 3 AR 46 O 5 V	46	117996	10	65,000	90,200	10
B 122 3 AR 80 O 5 V	80	118009	10	65,000	90,200	10
B 123 3 AR 100 O 5 V	100	118016	5	130,000	198,900	10
B 124 3 AR 100 O 5 V	100	118023	3	200,000	291,800	10
B 125 3 AR 100 O 5 V	100	118030	6	100,000	149,200	10
Shank dia. 3.17 x 30 mm [S_d x L₂]						
B 123 3,1 AR 100 O 5 V	100	115701	5	130,000	198,900	10
B 125 3,1 AR 100 O 5 V	100	115732	6	100,000	149,200	10



Mounted points for tool sharpening are ideally suited for general sharpening of all HSS cutting tools. They consist of a vitrified bond and an aluminium oxide base. Grain and hardness complement the diameter. These mounted points are supplied with reduced 6 mm shank.

Application examples:

- Re-sharpening of threading dies
- Grinding of HSS shape cutting tools
- Reduction of drill cutting edges
- Re-sharpening of step chip breakers on HSS tools

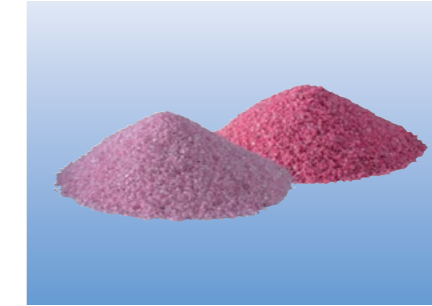
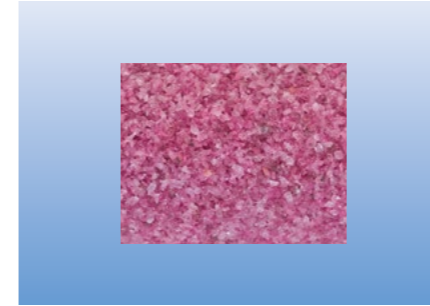
Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**098370**
702 6 AR **100** MO V
Please complete the description with the desired grit size.

Description	Grit size		D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	80	100				
EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L₂]						
702 6 AR ... MO V	-	098370	2 x 5	200,000	201,800	10
703 6 AR ... MO V	-	098387	3 x 8	152,500	152,500	10
704 6 AR ... MO V	-	098394	4 x 8	177,400	177,400	10
705 6 AR ... MO V	098400	-	5 x 8	170,000	190,900	10
706 6 AR ... MO V	098417	-	6 x 10	140,000	159,100	10
707 6 AR ... MO V	098424	-	7 x 10	120,000	136,400	10
708 6 AR ... MO V	098431	-	8 x 12	100,000	119,300	10
709 6 AR ... MO V	098448	-	9 x 12	106,100	106,100	10
710 6 AR ... MO V	098455	-	10 x 12	85,000	95,400	10
712 6 AR ... MO V	098479	-	12 x 15	70,000	79,500	10



Special mounted points in **hardness O for foundries** are manufactured from a specially developed bond and a grain mix of pink and red aluminium oxide. This grain combination results in a good balance of stock removal rate and tool life, especially when working on steel castings. The hardness O for foundries is particularly suitable for tough work on cast steel.

Advantages:

- Very high abrasiveness and aggressiveness right from the outset
- High stock removal rate in combination with long tool life
- Supplied in practical and environmentally friendly industrial packaging

Application examples:

- Removal of burrs on cast steel parts
- Grinding of intersections after separating risers

Recommendations for use:

- Mounted points of hardness O achieve their best performance at a cutting speed of 25 to 40 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

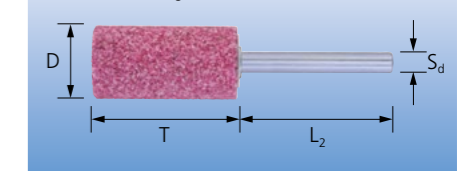
Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**802953**
ZY 2040 6 ADR 30 O 5 V na

Hardness O, cylindrical ZY



Description	Grit size	EAN 4007220	Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]							
ZY 2040 6 ADR 30 O 5 V na	30	802953	W 207	20 x 40	32,400	32,400	50
ZY 2532 6 ADR 30 O 5 V na	30	802960	-	25 x 32	25,000	32,900	50

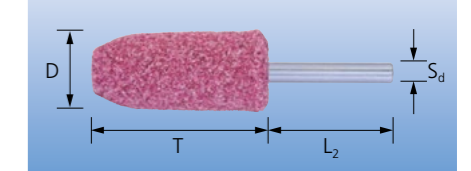
Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

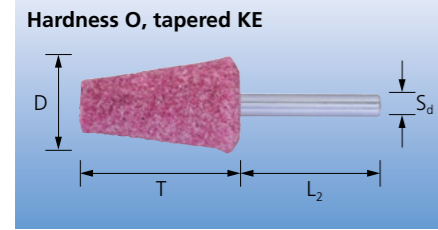
EAN 4007220**802977**
SP 2050 6 ADR 30 O 5 V na

Hardness O, tree SP



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]						
SP 2050 6 ADR 30 O 5 V na	30	802977	20 x 50	14,100	14,100	50





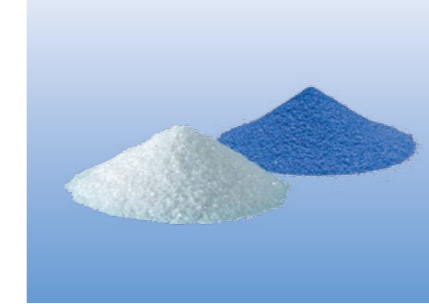
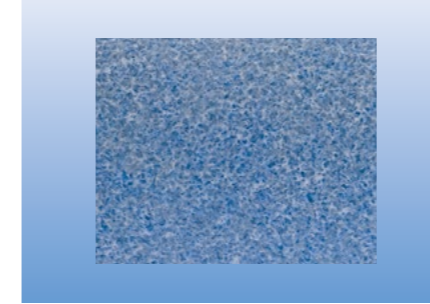
Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220802991
KE 1645 6 ADR 46 O 5 V na
Please complete the description with the desired grit size.

Description	Grit size			D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46				
	EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L₂]							
KE 1645 6 ADR ... O 5 V na	-	-	802991	16 x 45	24,000	24,000	50
KE 2040 6 ADR ... O 5 V na	-	803011	-	20 x 40	20,900	20,900	50
Shank dia. 8 x 40 mm [S_d x L₂]							
KE 3550 8 ADR ... O 5 V na	642672	-	-	35 x 50	15,600	15,600	50



Mounted points in **hardness J** are manufactured from a vitrified bond and a grain mix of white aluminium oxide and blue ceramic. The soft bond in combination with the easy-to-break-down, sharp-edged white aluminium oxide and the self-sharpening effect of the microcrystalline ceramic oxide grain allows extremely high stock removal rates with excellent tool life. The hardness J is perfectly suited for surface work on titanium materials, nickel- and cobalt-based alloys, hardened steel components and built-up weld deposits.

Advantages:

- Cool grinding due to the easy-to-break-down grain mix.
- High stock removal rate and very long tool life
- Constant stock removal through self-sharpening qualities of the ceramic oxide grain

Application examples:

- Re-finishing of turbine blades during aero-plane maintenance work
- Follow-up repair welding in tool and mould construction
- Grinding of repair welds on turbine blades

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220802106
ZY 0306 3 AWCO 80 J 5 V
Please complete the description with the desired grit size.

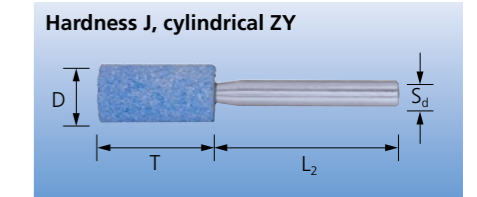
Recommendations for use:

- Mounted points of hardness J achieve their best performance at a cutting speed of 30 to 50 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives



PFERDVIDEO

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Description	Grit size							Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60	80	100	320					
	EAN 4007220											
Shank dia. 3 x 30 mm [S_d x L₂]												
ZY 0105 3 AWCO ... J 5 V	-	-	-	-	-	-	898383	-	1 x 5	104,200	104,200	10
ZY 1,508 3 AWCO ... J 5 V	-	-	-	-	-	-	898390	-	1.5 x 8	104,700	104,700	10
ZY 1,708 3 AWCO ... J 5 V	-	-	-	-	-	-	898406	-	1.7 x 8	112,300	112,300	10
ZY 0205 3 AWCO ... J 5 V	-	-	-	-	898413	898420	-	W 141	2 x 5	200,000	201,800	10
ZY 0306 3 AWCO ... J 5 V	-	-	-	898437	802106	802120	-	W 144	3 x 6	200,000	206,100	10
ZY 0408 3 AWCO ... J 5 V	-	-	-	898444	802137	802144	-	-	4 x 8	175,100	175,100	10
ZY 0510 3 AWCO ... J 5 V	-	-	-	898451	802151	802168	-	W 153	5 x 10	130,700	130,700	10
ZY 0613 3 AWCO ... J 5 V	-	-	898468	802175	802182	802199	-	W 163	6 x 13	93,600	93,600	10
ZY 0810 3 AWCO ... J 5 V	-	-	947852	-	-	-	-	W 169	8 x 10	87,600	87,600	10
ZY 0816 3 AWCO ... J 5 V	-	-	898475	898499	898505	-	-	-	8 x 16	61,000	61,000	10
ZY 1013 3 AWCO ... J 5 V	-	-	-	-	947869	-	-	W 176	10 x 13	58,400	58,400	10
ZY 1303 3 AWCO ... J 5 V	-	-	898567	898574	-	-	-	W 182	13 x 3	65,000	73,400	10
ZY 2006 3 AWCO ... J 5 V	-	-	898581	898598	-	-	-	W 201	20 x 6	45,000	47,700	10
Shank dia. 6 x 40 mm [S_d x L₂]												
ZY 0510 6 AWCO ... J 5 V	-	-	-	-	-	947876	-	W 153	5 x 10	157,800	157,800	10
ZY 0816 6 AWCO ... J 5 V	-	-	802205	-	802212	-	-	-	8 x 16	100,000	119,300	10
ZY 1013 6 AWCO ... J 5 V	-	-	802229	-	802274	-	-	W 176	10 x 13	85,000	95,400	10
ZY 1020 6 AWCO ... J 5 V	-	-	898512	-	898550	-	-	-	10 x 20	85,000	95,400	10
ZY 1325 6 AWCO ... J 5 V	-	-	802304	-	802311	-	-	W 187	13 x 25	65,000	66,000	10
ZY 1620 6 AWCO ... J 5 V	-	947883	802328	802335	-	-	-	W 195	16 x 20	55,000	59,600	10
ZY 1632 6 AWCO ... J 5 V	-	947890	802342	802366	-	-	-	-	16 x 32	51,200	51,200	10
ZY 2025 6 AWCO ... J 5 V	-	947906	802373	802397	-	-	-	W 205	20 x 25	45,000	47,700	10

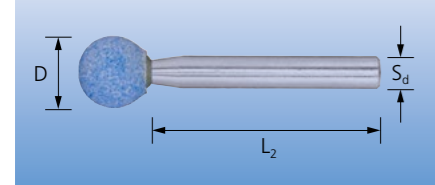
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Description	Grit size							Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60	80	100	320					
	EAN 4007220											
ZY 2040 6 AWCO ... J 5 V	-	947913	898604	898628	-	-	-	W 207	20 x 40	32,400	32,400	10
ZY 2525 6 AWCO ... J 5 V	-	947920	-	-	-	-	-	W 220	25 x 25	35,000	38,100	10
ZY 3216 6 AWCO ... J 5 V	-	-	947937	-	-	-	-	-	32 x 16	27,000	29,800	10
ZY 3232 6 AWCO ... J 5 V	947944	-	802427	-	-	-	-	W 230	32 x 32	25,700	25,700	5
ZY 4010 6 AWCO ... J 5 V	-	-	898635	898642	-	-	-	W 236	40 x 10	22,000	23,800	5
ZY 4020 6 AWCO ... J 5 V	-	-	802434	-	-	-	-	-	40 x 20	22,000	23,800	5

Hardness J, ball KU



Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**802465**
 KU 06 3 AWCO **80** J 5 V
 Please complete the description with the desired grit size.

Description	Grit size				D [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	46	60	80	100				
	EAN 4007220							

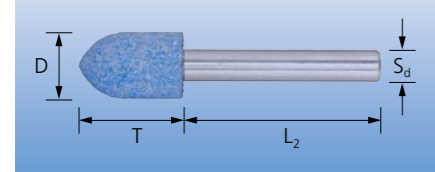
Shank dia. 3 x 30 mm [S_d x L₂]

KU 03 3 AWCO ... J 5 V	-	898659	898666	-	3	200,000	300,200	10
KU 06 3 AWCO ... J 5 V	-	898673	802465	802472	6	140,000	159,100	10
KU 08 3 AWCO ... J 5 V	898680	-	802489	802519	8	100,000	116,200	10

Shank dia. 6 x 40 mm [S_d x L₂]

KU 13 6 AWCO ... J 5 V	802533	802557	802595	-	13	65,000	73,400	10
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Hardness J, tree SP



Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**802663**
 SP 0613 3 AWCO **80** J 5 V
 Please complete the description with the desired grit size.

Description	Grit size				D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	46	60	80	100				
	EAN 4007220							

Shank dia. 3 x 30 mm [S_d x L₂]

SP 0306 3 AWCO ... J 5 V	-	898697	898703	898734	3 x 6	200,000	252,000	10
SP 0408 3 AWCO ... J 5 V	-	898741	898758	898765	4 x 8	195,400	195,400	10
SP 0510 3 AWCO ... J 5 V	-	-	-	948071	5 x 10	149,500	149,500	10
SP 0610 3 AWCO ... J 5 V	-	898789	-	-	6 x 10	134,100	134,100	10
SP 0613 3 AWCO ... J 5 V	898772	-	802663	802670	6 x 13	108,100	108,100	10
SP 0816 3 AWCO ... J 5 V	898796	802687	802694	802700	8 x 16	72,800	72,800	10

Shank dia. 6 x 40 mm [S_d x L₂]

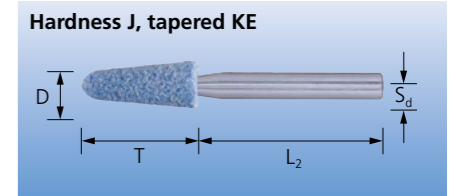
SP 1320 6 AWCO ... J 5 V	802717	802724	802731	-	13 x 20	65,000	73,400	10
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Safety notes:

■ The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**802601**
 KE 1025 6 AWCO **46** J 5 V
 Please complete the description with the desired grit size.

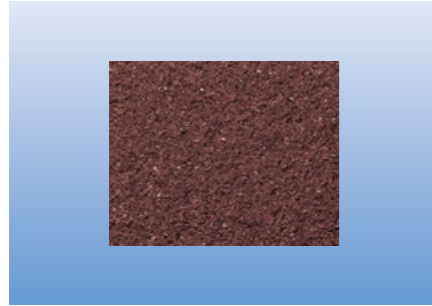


Description	Grit size		D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	46	60				
	EAN 4007220					

Shank dia. 6 x 40 mm [S_d x L₂]

KE 1025 6 AWCO ... J 5 V	802601	802618	10 x 25	85,000	95,400	10
KE 1645 6 AWCO ... J 5 V	802625	802656	16 x 45	52,000	52,000	10





Mounted points in **hardness L** are manufactured from a grain mix of white and dark red aluminium oxide and a high-quality resinoid bond. This relatively soft bond contains grinding additives and, in combination with the grain mix, leads to exceptionally high stock removal rates and a long tool life. The hardness L is particularly suited for surface work on stainless steel (INOX) and for general use on non-ferrous metals and bronze.

Advantages:

- Due to cool grinding, very suitable for use on temperature-sensitive materials
- High level of grinding comfort through low-vibration grinding

Application examples:

- Grinding of high-temperature-resistant alloy components
- Rough grinding of stainless steel (INOX) castings
- Grinding of components made of non-ferrous metals

Safety notes:

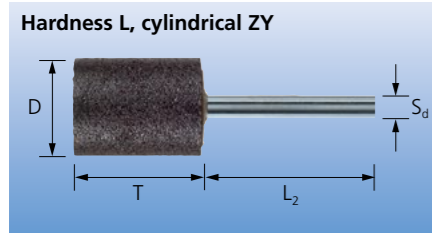
- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Recommendations for use:

- Mounted points of hardness L achieve their best performance at a cutting speed of 35 to 50 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

Ordering example:

EAN 4007220099742
ZY 3216 6 ADW 24 L 6 B
Please complete the description with the desired grit size.



Description	Grit size				Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46	60					
EAN 4007220									

Shank dia. 6 x 40 mm [S_d x L₂]

ZY 0816 6 ADW ... L 6 B	-	-	346877	-	-	8 x 16	100,000	119,300	10
ZY 1020 6 ADW ... L 6 B	-	-	346891	-	W 177	10 x 20	90,000	95,400	10
ZY 1032 6 ADW ... L 6 B	-	-	346907	-	W 179	10 x 32	62,800	62,800	10
ZY 1632 6 ADW ... L 6 B	-	096697	-	-	-	16 x 32	51,200	51,200	10
ZY 2025 6 ADW ... L 6 B	-	097083	-	346914	W 205	20 x 25	45,000	47,700	10
ZY 2040 6 ADW ... L 6 B	-	097304	-	-	W 207	20 x 40	32,400	32,400	10
ZY 2513 6 ADW ... L 6 B	-	099483	-	-	W 218	25 x 13	37,000	38,100	10
ZY 2525 6 ADW ... L 6 B	-	346938	-	-	W 220	25 x 25	37,000	38,100	10
ZY 2532 6 ADW ... L 6 B	-	097533	-	-	-	25 x 32	32,900	32,900	10
ZY 3216 6 ADW ... L 6 B	099742	-	-	-	-	32 x 16	29,000	29,800	5
ZY 3240 6 ADW ... L 6 B	097793	-	-	-	W 231	32 x 40	20,300	20,300	5
ZY 4006 6 ADW ... L 6 B	-	-	-	346976	W 235	40 x 6	23,000	23,800	5
ZY 4010 6 ADW ... L 6 B	-	099940	-	-	W 236	40 x 10	23,000	23,800	5
ZY 4020 6 ADW ... L 6 B	100127	-	-	-	-	40 x 20	23,000	23,800	5
ZY 5013 6 ADW ... L 6 B	-	100271	-	-	-	50 x 13	19,000	19,000	5
ZY 5025 6 ADW ... L 6 B	100394	-	-	-	W 242	50 x 25	19,000	19,000	5

Shank dia. 8 x 40 mm [S_d x L₂]

ZY 3240 8 ADW ... L 6 B	098257	-	-	-	W 231	32 x 40	28,500	29,800	5
ZY 5040 8 ADW ... L 6 B	100653	-	-	-	W 243	50 x 40	19,000	19,000	5

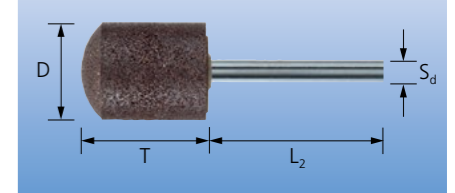
Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220353813
WR 2532 6 ADW 30 L 6 B

Hardness L, cylindrical with radius end WR



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]						
WR 2532 6 ADW 30 L 6 B	30	353813	25 x 32	37,000	37,300	10

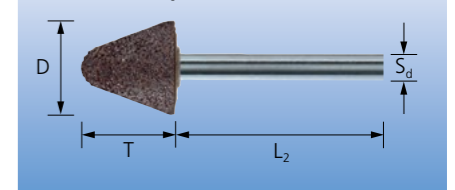
Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220660331
KE 2545 6 ADW 30 L 6 B

Hardness L, tapered KE



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]						
KE 2020 6 ADW 30 L 6 B	30	347034	20 x 20	45,000	47,700	10
KE 2545 6 ADW 30 L 6 B	30	660331	25 x 45	34,000	34,000	10

Explanation of the code system:

D = Mounted point outer dia.
T = Mounted point width

Ordering example:

EAN 4007220347096
A 1 6 ADW 60 L 6 B

Safety notes:

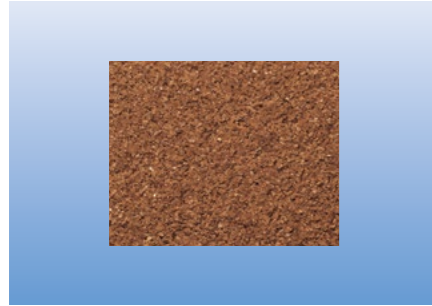
- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Hardness L, series A



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]						
A 1 6 ADW 60 L 6 B	60	347096	19 x 64	30,400	30,400	10
A 3 6 ADW 60 L 6 B	60	347119	25 x 70	18,600	18,600	10
A 11 6 ADW 60 L 6 B	60	347133	22 x 50	27,600	27,600	10





Mounted points in **hardness N** are manufactured from regular aluminium oxide and a high-quality resinoid bond. This relatively hard bond contains grinding additives, which in combination with tough regular aluminium oxide and the hard bond allow high stock removal rates and excellent tool life. The hardness N is particularly suited for edge grinding on stainless steel (INOX). It is characterized by cool grinding and high dimensional stability.

Advantages:

- Due to cool grinding, very suitable for use on temperature-sensitive materials
- High level of grinding comfort through low-vibration grinding
- Economical to use due to the high edge stability even on low-speed tool drives

Application examples:

- Grinding of fillet welds on high-grade steel components
- Removal of burrs on moulded high-temperature-resistant alloys
- Removal of burrs on cast stainless steel parts
- Grinding of chamfers in preparation for welding of stainless steel profiles

Recommendations for use:

- Mounted points of hardness N achieve their best performance at a cutting speed of 35 to 50 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

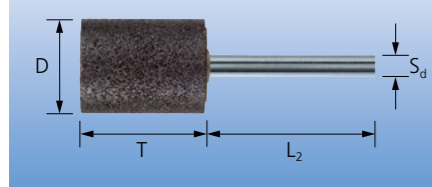
Ordering example:

EAN 4007220**096673**
ZY 1632 6 AN **30** N 5 B
Please complete the description with the desired grit size.

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Hardness N, cylindrical ZY



Description	Grit size				Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	📦
	24	30	46	60					
EAN 4007220									
Shank dia. 6 x 40 mm [S_d x L₂]									
ZY 0816 6 AN ... N 5 B	-	-	346860	-	-	8 x 16	100,000	119,300	10
ZY 1020 6 AN ... N 5 B	-	-	346884	-	W 177	10 x 20	92,000	95,400	10
ZY 1032 6 AN ... N 5 B	-	-	096062	-	W 179	10 x 32	62,800	62,800	10
ZY 1325 6 AN ... N 5 B	-	-	096420	-	W 187	13 x 25	66,000	66,000	10
ZY 1632 6 AN ... N 5 B	-	096673	-	096680	-	16 x 32	51,200	51,200	10
ZY 1650 6 AN ... N 5 B	-	096871	-	-	W 197	16 x 50	31,300	31,300	10
ZY 2008 6 AN ... N 5 B	-	346952	-	-	-	20 x 8	46,000	47,700	10
ZY 2025 6 AN ... N 5 B	-	097076	-	-	W 205	20 x 25	46,000	47,700	10
ZY 2040 6 AN ... N 5 B	-	097298	-	-	W 207	20 x 40	32,400	32,400	10
ZY 2506 6 AN ... N 5 B	-	-	346969	-	W 216	25 x 6	37,000	38,100	10
ZY 2513 6 AN ... N 5 B	-	099476	-	-	W 218	25 x 13	37,000	38,100	10
ZY 2532 6 AN ... N 5 B	-	097526	-	-	-	25 x 32	32,900	32,900	10
ZY 2540 6 AN ... N 5 B	-	098141	-	-	W 221	25 x 40	26,000	26,000	10
ZY 3208 6 AN ... N 5 B	-	099629	-	-	W 226	32 x 8	29,000	29,800	5
ZY 3216 6 AN ... N 5 B	099735	-	-	-	-	32 x 16	29,000	29,800	5
ZY 3220 6 AN ... N 5 B	099834	-	-	-	W 228	32 x 20	29,000	29,800	5
ZY 3232 6 AN ... N 5 B	097670	-	-	-	W 230	32 x 32	25,700	25,700	5
ZY 3240 6 AN ... N 5 B	097786	-	-	-	W 231	32 x 40	20,300	20,300	5
ZY 4006 6 AN ... N 5 B	-	-	100479	-	W 235	40 x 6	23,000	23,800	5

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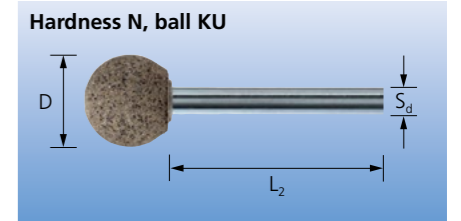
Description	Grit size				Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	📦
	24	30	46	60					
EAN 4007220									
ZY 4010 6 AN ... N 5 B	-	099933	-	-	-	40 x 10	23,000	23,800	5
ZY 4020 6 AN ... N 5 B	100110	-	-	-	-	40 x 20	23,000	23,800	5
ZY 4040 6 AN ... N 5 B	346945	-	-	-	W 238	40 x 40	16,200	16,200	5
ZY 5008 6 AN ... N 5 B	-	100523	-	-	-	50 x 8	19,000	19,000	5
ZY 5013 6 AN ... N 5 B	-	100264	-	-	-	50 x 13	19,000	19,000	5
ZY 5025 6 AN ... N 5 B	100387	-	-	-	W 242	50 x 25	19,000	19,000	5
Shank dia. 8 x 40 mm [S_d x L₂]									
ZY 3240 8 AN ... N 5 B	098240	-	-	-	W 231	32 x 40	28,500	29,800	5

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**347010**
KU 20 6 AN 30 N 5 B



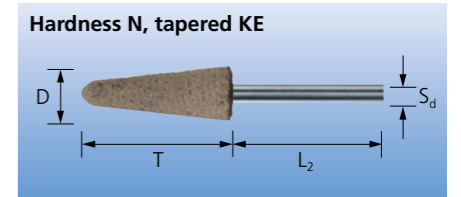
Description	Grit size	EAN 4007220	D [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	📦
Shank dia. 6 x 40 mm [S_d x L₂]						
KU 16 6 AN 30 N 5 B	30	347003	16	58,000	59,600	10
KU 20 6 AN 30 N 5 B	30	347010	20	46,000	47,700	10
KU 25 6 AN 30 N 5 B	30	347027	25	37,000	38,100	10

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

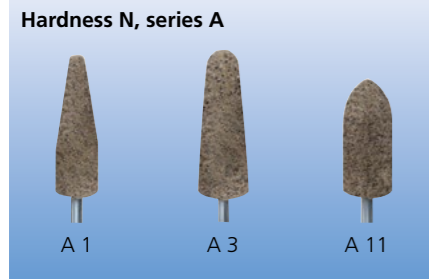
Ordering example:

EAN 4007220**347065**
KE 1645 6 AN **46** N 5 B
Please complete the description with the desired grit size.



Description	Grit size			D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	📦
	24	30	46				
EAN 4007220							
Shank dia. 6 x 40 mm [S_d x L₂]							
KE 1025 6 AN ... N 5 B	-	-	347041	10 x 25	92,000	95,400	10
KE 1645 6 AN ... N 5 B	-	-	347065	16 x 45	52,000	52,000	10
KE 2545 6 AN ... N 5 B	-	660324	-	25 x 45	34,000	34,000	10
KE 3232 6 AN ... N 5 B	347072	-	-	32 x 32	29,000	29,800	5





Explanation of the code system:

D = Mounted point outer dia.
T = Mounted point width

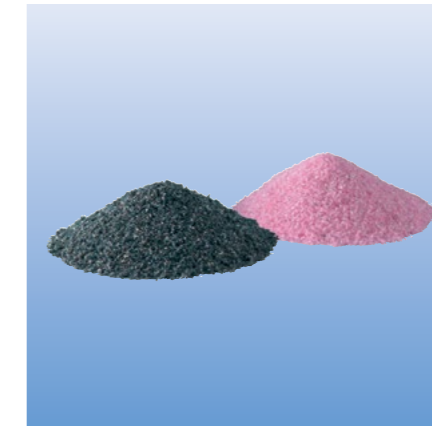
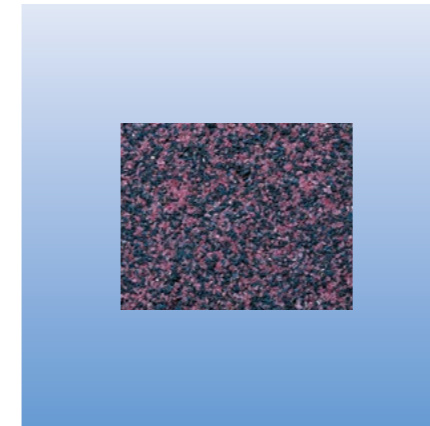
Ordering example:

EAN 4007220347089
A 1 6 AN 30 N 5 B

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]						
A 1 6 AN 30 N 5 B	30	347089	19 x 64	30,400	30,400	10
A 3 6 AN 30 N 5 B	30	347102	25 x 70	18,600	18,600	10
A 11 6 AN 30 N 5 B	30	347126	22 x 50	27,600	27,600	10
Shank dia. 6.35 x 40 mm [S_d x L₂]						
A 11 6,3 AN 30 N 5 B	30	347157	22 x 50	30,400	30,400	10



Mounted points in **hardness K** are manufactured from a grain mix of pink aluminium oxide and regular aluminium oxide in a vitrified bond. In a medium-hard bond, this abrasive grain combination leads to a good stock removal rate and a long tool life. The hardness K is particularly suitable for general use on cast iron parts when used with high peripheral speeds.

Advantages:

- Suitable for use on surfaces and edges
- High abrasiveness and long tool life
- High stock removal rate due to coarse grit sizes

Application examples:

- Cleaning of workpieces made from grey and nodular cast iron
- Grinding out of shrinkage holes in grey and nodular cast iron components

Recommendations for use:

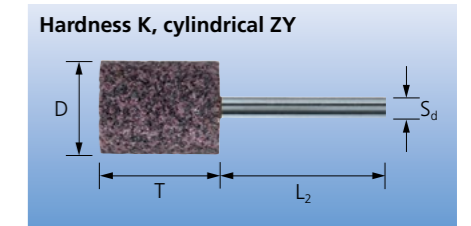
- Mounted points of hardness K achieve their best performance at a cutting speed of 30 to 50 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

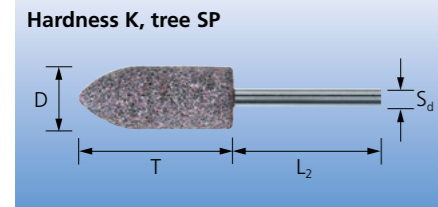
Ordering example:

EAN 4007220097564
ZY 3232 6 ARN 24 K 5 V
Please complete the description with the desired grit size.



Description	Grit size		Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30					
Shank dia. 6 x 40 mm [S_d x L₂]							
ZY 1632 6 ARN ... K 5 V	-	096567	-	16 x 32	51,200	51,200	10
ZY 1650 6 ARN ... K 5 V	-	096819	W 197	16 x 50	31,300	31,300	10
ZY 2025 6 ARN ... K 5 V	-	096963	W 205	20 x 25	43,000	47,700	10
ZY 2040 6 ARN ... K 5 V	-	097199	W 207	20 x 40	32,400	32,400	10
ZY 2532 6 ARN ... K 5 V	-	097410	-	25 x 32	32,900	32,900	10
ZY 3232 6 ARN ... K 5 V	097564	-	W 230	32 x 32	25,700	25,700	5
ZY 3240 6 ARN ... K 5 V	097694	-	W 231	32 x 40	20,300	20,300	5
ZY 4010 6 ARN ... K 5 V	-	099865	W 236	40 x 10	22,000	23,800	5
ZY 4020 6 ARN ... K 5 V	100004	-	-	40 x 20	22,000	23,800	5
ZY 5008 6 ARN ... K 5 V	-	100493	-	50 x 8	18,000	19,000	5
ZY 5013 6 ARN ... K 5 V	-	100165	-	50 x 13	18,000	19,000	5
Shank dia. 8 x 40 mm [S_d x L₂]							
ZY 3240 8 ARN ... K 5 V	098158	-	W 231	32 x 40	27,000	29,800	5
ZY 5025 8 ARN ... K 5 V	100530	-	W 242	50 x 25	18,000	19,000	5





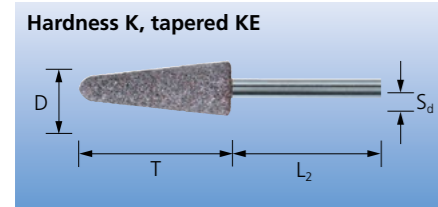
Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
SP 2050 6 ARN 30 K 5 V	30	102305	20 x 50	30,500	30,500	10

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220102305
SP 2050 6 ARN 30 K 5 V



Description	Grit size		D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	46				
	EAN 4007220					
Shank dia. 6 x 40 mm [S _d x L ₂]						
KE 1025 6 ARN ... K 5 V	-	534649	10 x 25	85,000	95,400	10
KE 1645 6 ARN ... K 5 V	-	102848	16 x 45	52,000	52,000	10
KE 2040 6 ARN ... K 5 V	534694	-	20 x 40	43,000	47,700	10

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220534649
KE 1025 6 ARN 46 K 5 V
Please complete the description with the desired grit size.



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
A 11 6 ARN 30 K 5 V	30	534700	22 x 50	27,600	27,600	10

Explanation of the code system:

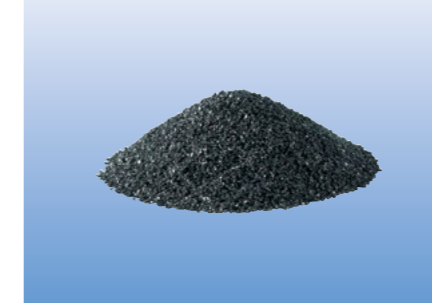
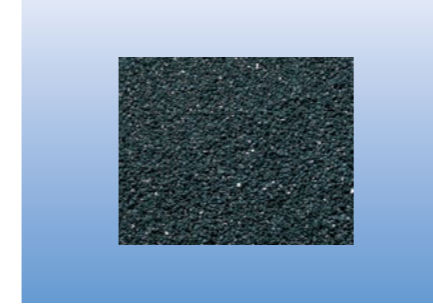
D = Mounted point outer dia.
T = Mounted point width

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220534700
A 11 6 ARN 30 K 5 V



Mounted points in **hardness R** are manufactured from grey silicon carbide in a vitrified bond. The combination of very hard abrasive grain and high bond content means that extremely long tool life is achieved when grinding. The hardness R is particularly suitable for use on edges and for grinding out metal contamination on grey and nodular cast iron at high cutting speeds.

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Advantages:

- Highly dimensionally stable due to the high bond content
- Economical to use due to the high edge stability even on low-speed tool drives

Application examples:

- Removal of sharp burrs on grey and nodular cast iron components
- Grinding of sand and metal contamination on cast parts

Ordering example:

EAN 4007220097069
ZY 2025 6 CU 30 R 5 V
Please complete the description with the desired grit size.

Recommendations for use:

- Mounted points of hardness R achieve their best performance at a cutting speed of 30 to 50 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

Description	Grit size		Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30					
	EAN 4007220						

Shank dia. 6 x 40 mm [S_d x L₂]

ZY 1632 6 CU ... R 5 V	-	096666	-	16 x 32	47,000	51,200	10
ZY 2025 6 CU ... R 5 V	-	097069	W 205	20 x 25	38,000	47,700	10
ZY 2040 6 CU ... R 5 V	-	097281	-	20 x 40	32,400	32,400	10
ZY 2050 6 CU ... R 5 V	-	098097	W 208	20 x 50	25,100	25,100	10
ZY 3232 6 CU ... R 5 V	097663	-	W 230	32 x 32	23,000	25,700	5
ZY 4020 6 CU ... R 5 V	100103	-	-	40 x 20	19,000	23,800	5

Shank dia. 8 x 40 mm [S_d x L₂]

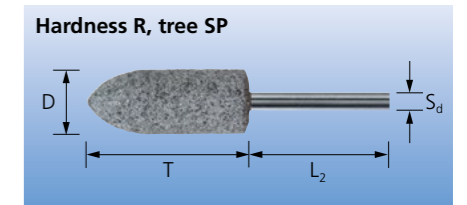
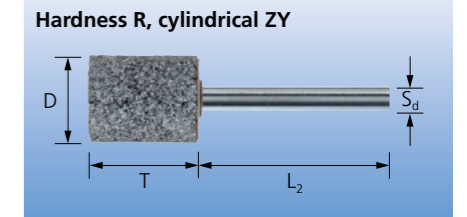
ZY 3240 8 CU ... R 5 V	098233	-	W 231	32 x 40	24,000	29,800	5
ZY 4040 8 CU ... R 5 V	098301	-	W 238	40 x 40	19,000	23,800	5

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220102282
SP 2032 6 CU 30 R 5 V



Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
SP 2032 6 CU 30 R 5 V	30	102282	20 x 32	38,000	47,700	10
SP 2050 6 CU 30 R 5 V	30	102336	20 x 50	30,500	30,500	10



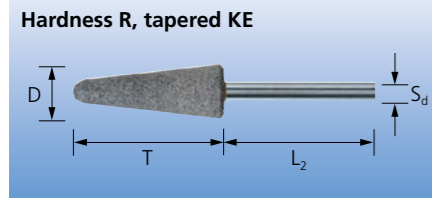
Mounted points

Hardness R



Mounted points

Hardness R for foundries



Hardness R, tapered KE

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

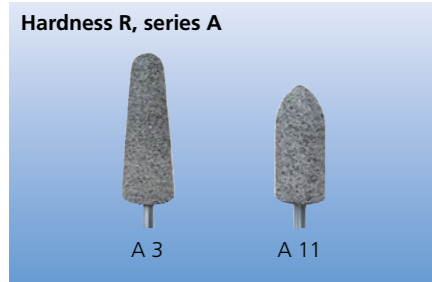
Ordering example:

EAN 4007220102725
KE 2032 6 CU 30 R 5 V
Please complete the description with the desired grit size.

Description	Grit size		D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	30	46				
EAN 4007220						

Shank dia. 6 x 40 mm [S_d x L₂]

KE 1645 6 CU ... R 5 V	-	102916	16 x 45	47,000	52,000	10
KE 2032 6 CU ... R 5 V	102725	-	20 x 32	38,000	47,700	10
KE 2545 6 CU ... R 5 V	102947	-	25 x 45	30,000	34,000	10



Hardness R, series A

Explanation of the code system:

D = Mounted point outer dia.
T = Mounted point width

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

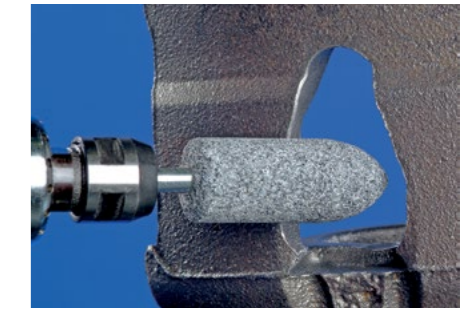
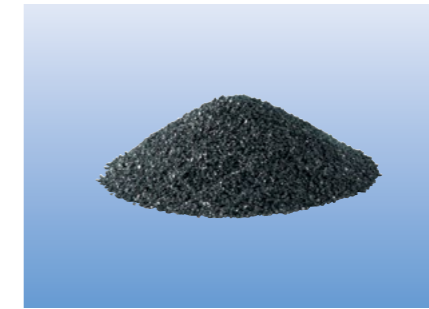
Ordering example:

EAN 4007220117156
A 3 6 CU 30 R 5 V

Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 6 x 40 mm [S_d x L₂]

A 3 6 CU 30 R 5 V	30	117156	25 x 70	18,600	18,600	10
A 11 6 CU 30 R 5 V	30	117217	22 x 50	27,600	27,600	10



Special mounted points in **hardness R for foundries** are manufactured from grey silicon carbide and a specially developed vitrified bond. The combination of extremely hard, sharp abrasive grain and the special bond gives long tool life with tough, aggressive grinding. The hardness R for foundries is particularly suitable for general use and for grinding out metal contamination on grey and nodular cast iron at high cutting speeds.

Advantages:

- Very high abrasiveness and aggressiveness right from the outset
- High stock removal rate in combination with long tool life
- Supplied in practical and environmentally friendly industrial packaging

Recommendations for use:

- Mounted points of hardness R achieve their best performance at a cutting speed of 30 to 50 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

Application examples:

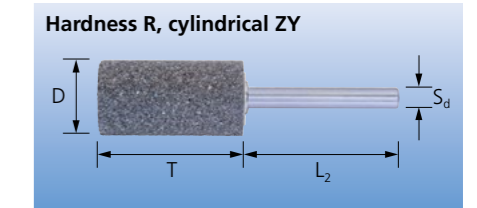
- Grinding out metal contamination on grey and nodular cast iron components
- Grinding of sand contamination and sand deposits on cast components

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220803028
ZY 2040 6 CU 30 R 5 V na



Hardness R, cylindrical ZY

Description	Grit size	EAN 4007220	Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 6 x 40 mm [S_d x L₂]

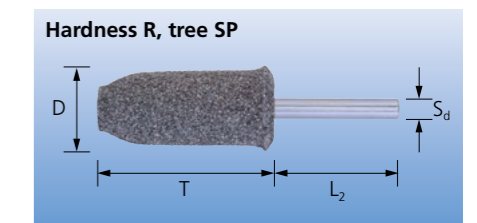
ZY 2040 6 CU 30 R 5 V na	30	803028	W 205	20 x 40	32,400	32,400	50
ZY 2532 6 CU 30 R 5 V na	30	803035	-	25 x 32	30,000	32,900	50

Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220803042
SP 2050 6 CU 30 R 5 V na



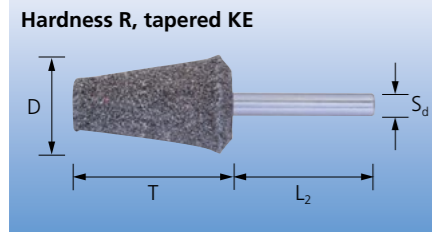
Hardness R, tree SP


Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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Shank dia. 6 x 40 mm [S_d x L₂]

SP 2050 6 CU 30 R 5 V na	30	803042	20 x 50	14,100	14,100	50
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Description	Grit size			D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
	24	30	46				
EAN 4007220							

Shank dia. 6 x 40 mm [S_d x L₂]

KE 1645 6 CU ... R 5 V na	-	-	803059	16 x 45	24,000	24,000	50
KE 2040 6 CU ... R 5 V na	-	803066	-	20 x 40	20,900	20,900	50

Shank dia. 8 x 40 mm [S_d x L₂]

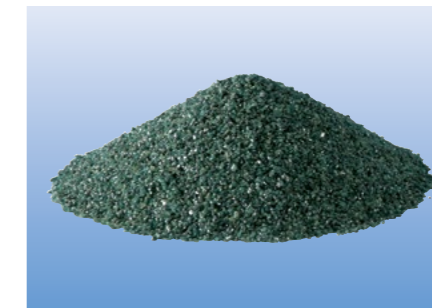
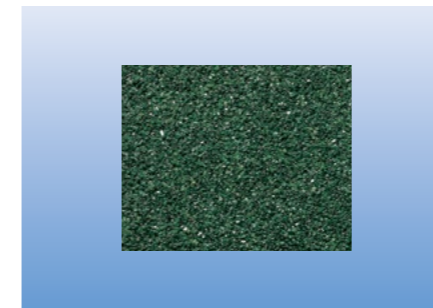
KE 3550 8 CU ... R 5 V na	642665	-	-	35 x 50	15,600	15,600	50
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Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**803059**
 KE 1645 6 CU **46** R 5 V na
 Please complete the description with the desired grit size.



Mounted points in **hardness F-ALU** are manufactured from green silicon carbide in a vitrified bond. The extremely open microstructure and a special impregnation allow extremely high stock removal rates when working on lubricating materials. The hardness F-ALU is produced especially for general use on aluminium and non-ferrous metals and is characterized by its high abrasive qualities and stock removal.

Advantages:

- Due to the special impregnation, there is no loading when working on soft, lubricating or tough materials
- High abrasion and stock removal rate

Application examples:

- Removal of burrs on cast aluminium components
- Grinding of brass, zinc and copper
- Grinding of chamfers for welding seam preparation on aluminium profiles

Recommendations for use:

- Mounted points of hardness F-ALU achieve their best performance at a cutting speed of 20 to 40 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

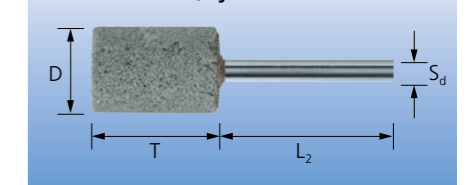
Safety notes:


- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220**097151**
 ZY 2032 6 CN 80 F 10 V ALU

Hardness F-ALU, cylindrical ZY



Description	Grit size	EAN 4007220	Acc. to US shape	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
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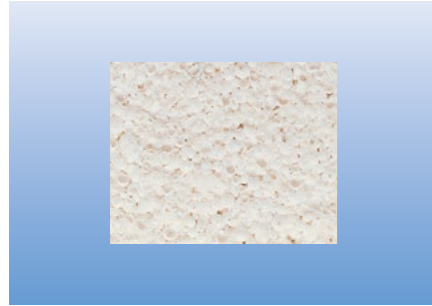
Shank dia. 3 x 30 mm [S_d x L₂]

ZY 0306 3 CN 80 F 10 V ALU	80	948101	W 144	3 x 6	159,000	206,100	10
ZY 0613 3 CN 80 F 10 V ALU	80	948118	W 163	6 x 13	93,600	93,600	10

Shank dia. 6 x 40 mm [S_d x L₂]

ZY 1013 6 CN 80 F 10 V ALU	80	802908	W 176	10 x 13	45,000	95,400	10
ZY 1320 6 CN 80 F 10 V ALU	80	802915	W 186	13 x 20	35,000	73,400	10
ZY 1620 6 CN 80 F 10 V ALU	80	096512	W 195	16 x 20	30,000	59,600	10
ZY 1632 6 CN 80 F 10 V ALU	80	802939	-	16 x 32	30,000	51,200	10
ZY 2032 6 CN 80 F 10 V ALU	80	097151	W 206	20 x 32	24,000	41,100	10
ZY 3232 6 CN 80 F 10 V ALU	80	802946	W 230	32 x 32	15,000	25,700	5
ZY 4020 6 CN 80 F 10 V ALU	80	100080	-	40 x 20	12,000	23,800	5





Mounted points in **hardness D** are manufactured from a special vitrified bond and bubble grain aluminium oxide (HKK). The low bond volume in combination with the easy-to-break-down bubble grain produces the softest mounted points in the PFERD product range. The hardness D is particularly suitable for work on soft materials such as plastic, rubber and wood, and is characterized by its high abrasiveness.

Advantages:

- Open structure and large chip spaces through bubble grain aluminium oxide
- Machining of temperature-sensitive materials without addition of cooling lubricant due to large chip spaces

Application examples:

- Removal of burrs on plastic injection components
- Trimming of rubber moulded parts and moulded parts made of polyurethane (PUR)
- Grinding of wooden cores and wooden shapes in model construction workshops

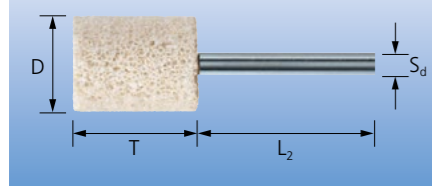
Recommendations for use:

- Mounted points of hardness D achieve their best performance at a cutting speed of 5 to 20 m/s
- Flexible shafts, electric grinders and air-powered straight grinders are suitable as tool drives

Ordering example:

EAN 4007220096703
ZY 1632 6 AH 1 D 12 V HKK

Hardness D, cylindrical ZY

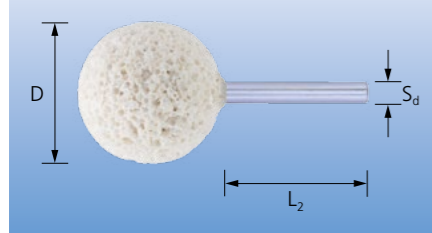


Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Description	Grit size	EAN 4007220	D x T [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]						
ZY 1632 6 AH 1 D 12 V HKK	1	096703	16 x 32	12,000	51,200	10
ZY 2532 6 AH 1 D 12 V HKK	1	097540	25 x 32	8,000	32,900	10
ZY 4020 6 AH 2 D 12 V HKK	2	100134	40 x 20	5,000	23,800	5

Hardness D, ball KU



Safety notes:

- The maximum permitted rotational speed refers to the unsupported shank length of 10 mm

Ordering example:

EAN 4007220948095
KU 40 6 AH 2 D 12 V HKK

Description	Grit size	EAN 4007220	D [mm]	Rec. speed [RPM]	Max. perm. speed [RPM]	
Shank dia. 6 x 40 mm [S_d x L₂]						
KU 40 6 AH 2 D 12 V HKK	2	948095	40	5,000	19,700	10

Dressing stone SE 1203050 CU 30 R 5 V
Dressing stone with coarse grit (grit size 30) for coarse dressing work. The rubber backing provides a slip-free grip and protects the support surfaces from damage.

Dressing stone SE 1203050 CU 30/60 R 5 V

- Dressing stone with two different grit sizes:
- Upper side (coarse): Profiling and dressing of large mounted points with coarse bonds and grit
 - Underside (fine): Profiling and dressing of mounted points with fine bonds and grit

Dressing stone SE 702212 CU 46 M 5 V
Small dressing stone with finer grit for profiling and dressing of smaller mounted points

Dressing stones



Description	EAN 4007220	Dimensions [mm]	
SE 1203050 CU 30 R 5 V	103500	120 x 30 x 50	5
SE 1203050 CU 30/60 R 5 V	505687	120 x 30 x 50	5
SE 702212 CU 46 M 5 V	114445	70 x 22 x 12	5



Wedge-shaped abrasive segments for work on sand moulds and cores in foundries.

Using the abrasive segments, the intersections and separators on sand moulds and cores can be re-finished and removed.

The wedge-shaped design allows work in both narrow areas and on large surfaces.

Abrasive segments



Description	EAN 4007220	Dimensions [mm]	
SE 235-42-4 AN 46 N 5 B	800034	235 x 42 x 4	10
SE 246-32-5 AN 46 N 5 B	800041	246 x 32 x 5	10

Long-life diamond dresser with large single grit diamond for profiling and dressing mounted points, grinding discs and Poliflex® grinding points (see Catalogue 204).

Using this diamond dresser, blunt grit and metal particles can be removed from the grinding tool, and the required grinding wheel shapes can be produced.

Recommendations for use:

- Protect the diamond dresser from impact and impact-type loads
- Clamp deeply and ensure it is well tightened
- Insert at an angle of 5 to 15 degrees, just below the mounted points or the disc centre

Diamond dresser



Description	EAN 4007220	Dimensions [mm]	
400 B	103494	81 x 6	1



Mounted point sets

Mounted point sets

Mounted point sets 2001



Contain 10 mounted points with shank diameter 6 mm in the most common shapes and dimensions.

Available in two hardness grades.

Set 2001 J G

Contents:

1 piece each
ZY 1013, ZY 1325, ZY 1620, ZY 2025,
ZY 2040, ZY 4010, KU 13, SP 1320, KE 1025,
KE 1645

Recommendations for use:

■ Mounted points of hardness J achieve their best performance at a cutting speed of 30 to 50 m/s


Set 2001 O G

Contents:

1 piece each
ZY 1013, ZY 1320, ZY 2006, ZY 2013,
ZY 2025, KU 16, WR 2025, KE 2032, SP 1320,
KE 2020

Recommendations for use:

■ Mounted points of hardness O achieve their best performance at a cutting speed of 25 to 40 m/s

Description	EAN 4007220	Hardness grade	Grit size	Shank dia. S _d [mm]	
2001 J G	947609	J	coarse	6	1
2001 O G	114469	O	coarse	6	1

Mounted point sets 2002



Contain 15 small mounted points with shank diameter 3 mm in the most common shapes and dimensions for fine work and multi-purpose use.

Available in two hardness grades.

Set 2002 J F

Contents:

1 piece each
ZY 0205, ZY 0306, ZY 0408, ZY 0510,
ZY 0613, ZY 0816, ZY 1303, ZY 2006, KU 03,
KU 06, KU 08, SP 0306, SP 0408, SP 0613,
SP 0816

Set 2002 O F

Contents:

2 pieces each
ZY 0510, ZY 0810, ZY 1604


1 piece each
ZY 0408, ZY 0613, ZY 0802, ZY 1013,
ZY 1303, WR 0510, KU 05, SP 0306, SP 0816

Recommendations for use:

■ Mounted points of hardness O achieve their best performance at a cutting speed of 25 to 40 m/s

Recommendations for use:

■ Mounted points of hardness J achieve their best performance at a cutting speed of 30 to 50 m/s

Description	EAN 4007220	Hardness grade	Grit size	Shank dia. S _d [mm]	
2002 J F	947616	J	fine	3	1
2002 O F	114476	O	fine	3	1

Mounted point set SSO 5300



Contain 100 mounted points of hardness M with shank diameter 6 mm in the most common shapes and dimensions for common applications.


Delivered in sales-promoting display boxes for the point of sale in shops.

Contents:

10 pieces each
ZY 1620, ZY 2025, ZY 2506, ZY 2532,
ZY 3216, ZY 3232, ZY 4020, SP 2032,
KE 2032, KE 2570

Recommendations for use:

Mounted points of hardness M achieve their best performance at a cutting speed of 30 to 50 m/s

Description	EAN 4007220	Hardness grade	Grit size	Shank dia. S _d [mm]	
SSO 5300	114513	M	coarse	6	1

